





Solid drilling and bore machining

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2 Solid carbide drilling

3 Indexable insert drilling

4 Reaming and Countersinking

5 Spindle Tooling

Threading

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7 Circular and Thread Milling

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WNT \ Performance

Premium quality tools for high performance.

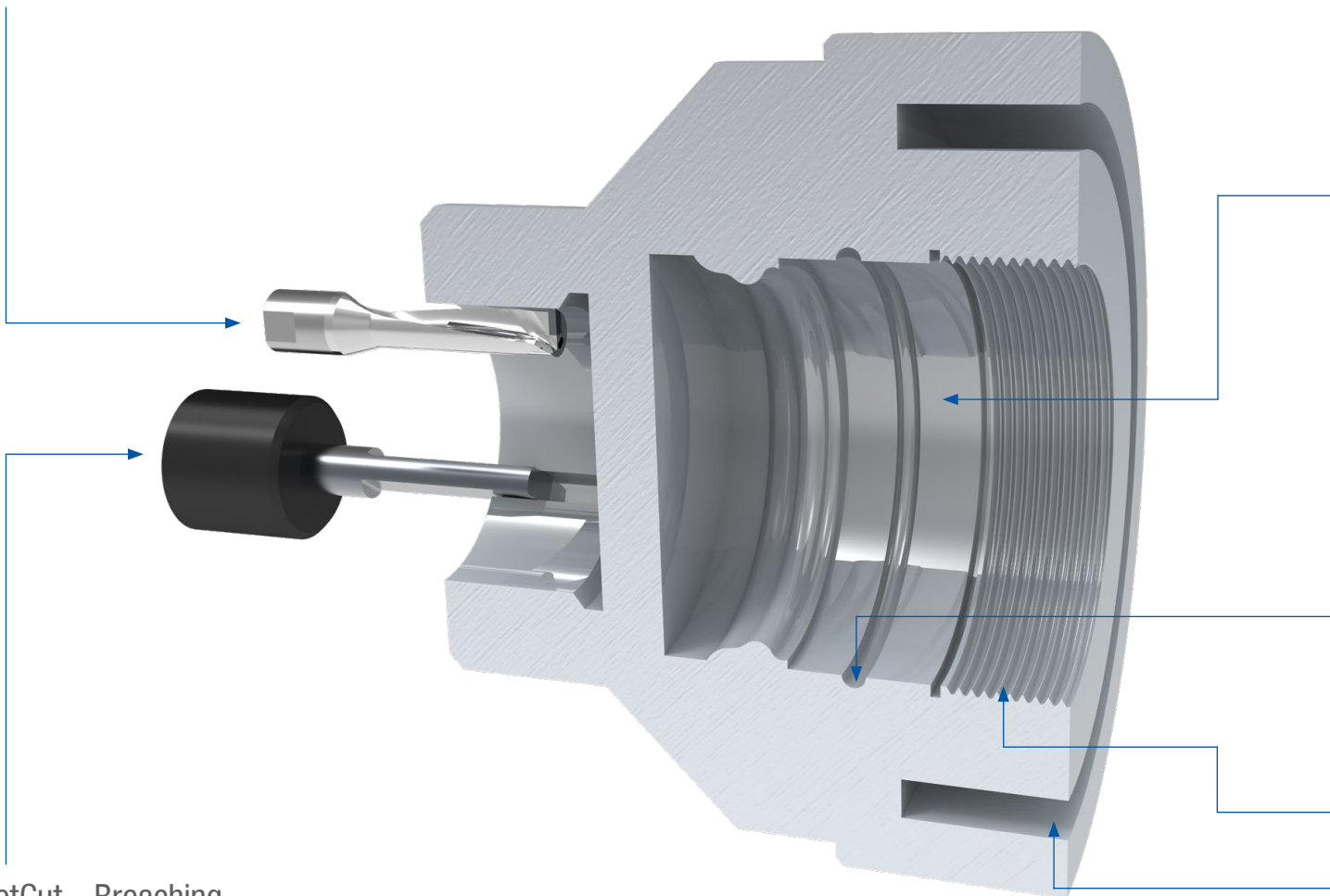
The premium quality tools from the **WNT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

Toolfinder

EcoCut Mini

From \varnothing 2 mm

Inserts and tool holders can be found in → **Chapter 10 – EcoCut**



SlotCut – Broaching

Inserts + Holder DIN138

55-58

System overview

UltraMini



- ▲ from Ø 0.5 mm
- ▲ flexible system
- ▲ ground inserts
- ▲ high repeatability
- ▲ coolant supply to the cutting edge

MiniCut



- ▲ from Ø 7.8 mm
- ▲ stable three-rib interface
- ▲ easy handling
- ▲ coolant supply to the cutting edge
- ▲ precise cutting edge position

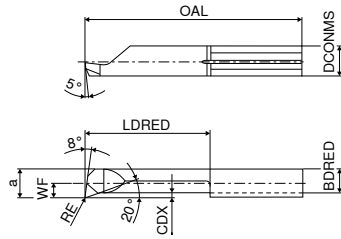
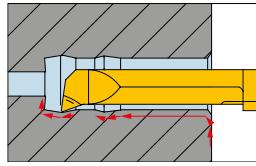
SlotCut



- ▲ broaching directly on the machine
- ▲ usable from Ø 6 mm
- ▲ low machine load
- ▲ variety of tolerance classes

Hole diameter in mm	UltraMini										MiniCut						
		≥ 0,5	≥ 2	≥ 2,4	≥ 2,8	≥ 3	≥ 4	≥ 5	≥ 6	≥ 8	≥ 16		≥ 8	≥ 9	≥ 11	≥ 14	≥ 16
Internal turning and profiling		4-7	4-7	4-7	4-7		4-7	4-7	4-7				36	36	36	36	36
Internal turning and profiling - hard turning			8		8		8	8	8				37		37	37	37
High-feed turning			10			10	10	10	10								
Turning and profile turning - super alloys			9		9		9	9	9								
Internal turning					11		11	11					38	38	38	38	38
Back boring						12	12	12	12				39	39	39	39	
Turning and chamfering								13	13				39	39	39	39	
Pre-parting and chamfering							13	13	13				40	40	40	40	40
Groove turning			14-16			14-16	14-16	14-16	14-16				41+42	40	40	40	40
Internal Undercuts			17		17		17	17	17				43	43	43	43	43
Groove and profile turning							18	18	18				44	44	44	44	44
Internal thread turning				19-22			19-22	19-22	19-22				45-48	45-48	45-48	45-48	45-48
Axial grooving								23-28	23-28	23-28	23-28		49+50	49+50	49+50	49+50	49+50
Suitable holder							31-35										51-54
Sets							29+30										50

UltraMini – Inserts for internal turning and profiling

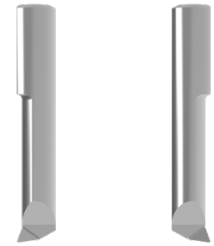
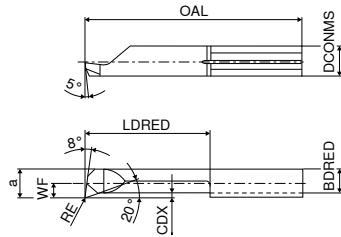
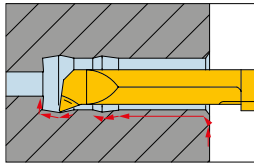


Illustrations show right-hand versions

Designation	DCONMS _{HS} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand	
											Article no. 73 005 ...	Article no. 73 004 ...	Article no. 73 005 ...	Article no. 73 004 ...	
R/L 050.05-2	4		0,5	0,4	20	2	0,03	0,32	0,02	645.00..D	500		500		
R/L 050.06-2	4		0,6	0,5	20	2	0,05	0,40	0,04	645.00..D	510		510		
R/L 050.06-3	4		0,6	0,5	20	3	0,05	0,40	0,04	645.00..D	511		511		
R/L 050.08-4	4		0,8	0,7	20	4	0,05	0,60	0,04	645.00..D				812	812
R/L 050.1-8	4		1,0	0,9	22	8	0,10	0,75	0,05	645.00..D				813	813
R/L 050.15-5	4		1,5	1,3	19	5	0,10	1,15	0,05	645.00..D	515		515		
R/L 050.15-10	4		1,5	1,3	24	10	0,10	1,15	0,05	645.00..D	516		516		
R/L 050.15-12	4		1,5	1,3	26	12	0,10	1,15	0,05	645.00..D				818	818
R/L 050.2-5	4		2,0	1,7	19	5	0,10	1,50	0,05	645.00..D	520		520		
R/L 050.2-10	4		2,0	1,7	24	10	0,10	1,50	0,05	645.00..D	521		521		
R/L 050.2-15	4		2,0	1,7	29	15	0,10	1,50	0,05	645.00..D	522		522		
R/L 050.3-10	4	0,6	2,8	2,6	24	10	0,20	2,30	0,10	645.00..D	531		531		
R/L 050.3-16	4	0,6	2,8	2,6	30	16	0,20	2,30	0,10	645.00..D	530		530		
R/L 050.3-20	4	0,6	2,8	2,6	34	20	0,20	2,30	0,10	645.00..D	532		532		
R/L 050.35-10	4	1,1	3,5	3,1	24	10	0,25	2,80	0,10	645.00..D				835	835
R/L 050.35-16	4	1,1	3,5	3,1	30	16	0,25	2,80	0,10	645.00..D				836	836
R/L 050.35-20	4	1,1	3,5	3,1	34	20	0,25	2,80	0,10	645.00..D				837	837
R/L 050.35-24	4	1,1	3,5	3,1	38	24	0,25	2,80	0,10	645.00..D				838	838
R/L 050.4-10	4	1,5	4,0	3,5	24	10	0,30	3,00	0,10	645.00..D	541		541	841	841
R/L 050.4-16	4	1,5	4,0	3,5	30	16	0,30	3,00	0,10	645.00..D	540		540	840	840
R/L 050.4-20	4	1,5	4,0	3,5	34	20	0,30	3,00	0,10	645.00..D	542		542	842	842
R/L 050.4-24	4	1,5	4,0	3,5	38	24	0,30	3,00	0,10	645.00..D	545		545	845	845
R/L 050.4-28	4	1,5	4,0	3,5	42	28	0,30	3,00	0,10	645.00..D	546		546	846	846
R/L 050.5-10	5	1,9	5,0	4,4	25	10	0,50	3,80	0,15	645.00..D	551		551	851	851
R/L 050.5-15	5	1,9	5,0	4,4	30	15	0,50	3,80	0,15	645.00..D	552		552	852	852
R/L 050.5-20	5	1,9	5,0	4,4	35	20	0,50	3,80	0,15	645.00..D	550		550	850	850
R/L 050.5-25	5	1,9	5,0	4,4	40	25	0,50	3,80	0,15	645.00..D	553		553	853	853
R/L 050.5-30	5	1,9	5,0	4,4	45	30	0,50	3,80	0,15	645.00..D	554		554	854	854
R/L 050.5-35	5	1,9	5,0	4,4	50	35	0,50	3,80	0,15	645.00..D	556		556	856	856
R/L 050.5-40	5	1,9	5,0	4,4	55	40	0,50	3,80	0,15	645.00..D				857	857
R/L 050.6-15	6	2,3	6,0	5,3	30	15	0,50	4,50	0,15	676.00..D	561		561	861	861
R/L 050.6-22	6	2,3	6,0	5,3	37	22	0,50	4,50	0,15	676.00..D	560		560	860	860
R/L 050.6-25	6	2,3	6,0	5,3	40	25	0,50	4,50	0,15	676.00..D	562		562	862	862
R/L 050.6-30	6	2,3	6,0	5,3	45	30	0,50	4,50	0,15	676.00..D	563		563	863	863
R/L 050.6-35	6	2,3	6,0	5,3	50	35	0,50	4,50	0,15	676.00..D	564		564	864	864
R/L 050.6-42	6	2,3	6,0	5,3	57	42	0,50	4,50	0,15	676.00..D	565		565	865	865
R/L 050.7-20	7	2,8	6,8	6,3	35	20	0,60	5,50	0,15	676.00..D	572		572	872	872
R/L 050.7-25	7	2,8	6,8	6,3	40	25	0,60	5,50	0,15	676.00..D	573		573	873	873
R/L 050.7-30	7	2,8	6,8	6,3	45	30	0,60	5,50	0,15	676.00..D	574		574	874	874
R/L 050.7-35	7	2,8	7,0	6,3	50	35	0,60	5,50	0,15	676.00..D	575		575	875	875
R/L 050.7-40	7	2,8	7,0	6,3	55	40	0,60	5,50	0,15	676.00..D	576		576	876	876
R/L 050.7-45	7	2,8	7,0	6,3	60	45	0,60	5,50	0,15	676.00..D	577		577	877	877
R/L 050.7-50	7	2,8	7,0	6,3	65	50	0,60	5,50	0,15	676.00..D	578		578	878	878

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

UltraMini – Inserts for internal turning and profiling



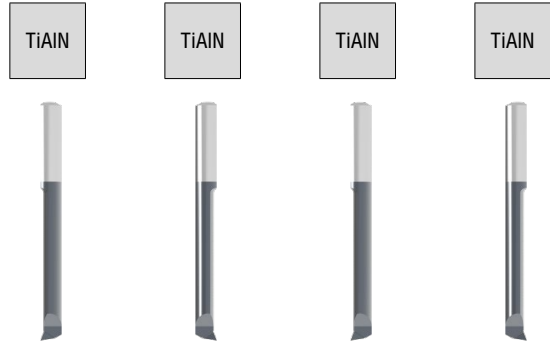
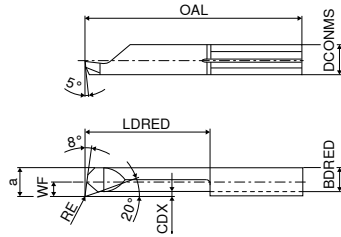
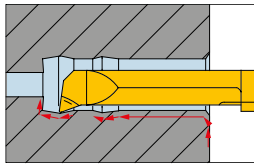
Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand	Right-hand
											Article no. 73 005 ...	Article no. 73 004 ...
R/L 050.2-5	4		2,0	1,7	19	5	0,1	1,5	0,05	645.00..D	020	020
R/L 050.2-10	4		2,0	1,7	24	10	0,1	1,5	0,05	645.00..D	021	021
R/L 050.2-15	4		2,0	1,7	29	15	0,1	1,5	0,05	645.00..D	022	022
R/L 050.3-10	4	0,6	2,8	2,6	24	10	0,2	2,3	0,10	645.00..D	031	031
R/L 050.3-16	4	0,6	2,8	2,6	30	16	0,2	2,3	0,10	645.00..D	030	030
R/L 050.3-20	4	0,6	2,8	2,6	34	20	0,2	2,3	0,10	645.00..D	032	032
R/L 050.4-10	4	1,5	4,0	3,5	24	10	0,3	3,0	0,10	645.00..D	041	041
R/L 050.4-16	4	1,5	4,0	3,5	30	16	0,3	3,0	0,10	645.00..D	040	040
R/L 050.4-20	4	1,5	4,0	3,5	34	20	0,3	3,0	0,10	645.00..D	042	042
R/L 050.5-10	5	1,9	5,0	4,4	25	10	0,5	3,8	0,15	645.00..D	051	051
R/L 050.5-15	5	1,9	5,0	4,4	30	15	0,5	3,8	0,15	645.00..D	052	052
R/L 050.5-20	5	1,9	5,0	4,4	35	20	0,5	3,8	0,15	645.00..D	050	050
R/L 050.5-25	5	1,9	5,0	4,4	40	25	0,5	3,8	0,15	645.00..D	053	053
R 050.5-30	5	1,9	5,0	4,4	45	30	0,5	3,8	0,05	645.00..D		054
L 050.5-30	5	1,9	5,0	4,4	45	30	0,5	3,8	0,15	645.00..D	054	
R/L 050.6-15	6	2,3	6,0	5,3	30	15	0,5	4,5	0,15	676.00..D	061	061
R/L 050.6-22	6	2,3	6,0	5,3	37	22	0,5	4,5	0,15	676.00..D	060	060
R/L 050.6-25	6	2,3	6,0	5,3	40	25	0,5	4,5	0,15	676.00..D	062	062
R/L 050.6-30	6	2,3	6,0	5,3	45	30	0,5	4,5	0,15	676.00..D	063	063
R/L 050.7-20	7	2,8	6,8	6,3	35	20	0,6	5,5	0,15	676.00..D	072	072
R/L 050.7-25	7	2,8	6,8	6,3	40	25	0,6	5,5	0,15	676.00..D	073	073
R/L 050.7-30	7	2,8	6,8	6,3	45	30	0,6	5,5	0,15	676.00..D	074	074
Steel											○	○
Stainless steel												
Cast iron											○	○
Non ferrous metals											●	●
Heat resistant alloys												
hardened materials												

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UltraMini – Inserts for internal turning and profiling

▲ with corner radius ≤ 0.05 mm



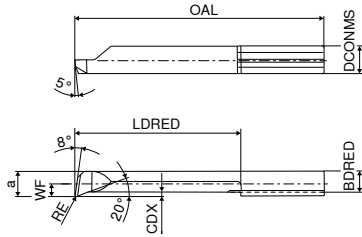
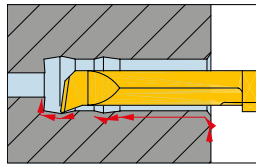
Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand
											Article no. 73 021 ...	Article no. 73 020 ...	Article no. 73 023 ...	Article no. 73 022 ...
R/L 053.3-10	4	0,6	2,8	2,6	24	10	0,2	2,3	0,03	645.00..D	310			
R/L 053.3-16	4	0,6	2,8	2,6	30	16	0,2	2,3	0,03	645.00..D	316			
R/L 053.3-20	4	0,6	2,8	2,6	34	20	0,2	2,3	0,03	645.00..D	320			
R/L 053.4-10	4	1,5	4,0	3,5	24	10	0,3	3,0	0,03	645.00..D	410			
R/L 053.4-16	4	1,5	4,0	3,5	30	16	0,3	3,0	0,03	645.00..D	416			
R/L 053.4-20	4	1,5	4,0	3,5	34	20	0,3	3,0	0,03	645.00..D	420			
R/L 053.4-24	4	1,5	4,0	3,5	38	24	0,3	3,0	0,03	645.00..D	424			
R/L 053.4-28	4	1,5	4,0	3,5	42	28	0,3	3,0	0,03	645.00..D	428			
R/L 055.2-10	4		2,0	1,7	24	10	0,1	1,5	0,05	645.00..D			210	210
R/L 055.2-15	4		2,0	1,7	29	15	0,1	1,5	0,05	645.00..D			215	215
R/L 055.2-5	4		2,0	1,7	19	5	0,1	1,5	0,05	645.00..D			205	205
R/L 055.3-10	4	0,6	2,8	2,6	24	10	0,2	2,3	0,05	645.00..D			310	310
R/L 055.3-16	4	0,6	2,8	2,6	30	16	0,2	2,3	0,05	645.00..D			316	316
R/L 055.3-20	4	0,6	2,8	2,6	34	20	0,2	2,3	0,05	645.00..D			320	320
R/L 055.4-10	4	1,5	4,0	3,5	24	10	0,3	3,0	0,05	645.00..D			410	410
R/L 055.4-16	4	1,5	4,0	3,5	30	16	0,3	3,0	0,05	645.00..D			416	416
R/L 055.4-20	4	1,5	4,0	3,5	34	20	0,3	3,0	0,05	645.00..D			420	420
R/L 055.4-24	4	1,5	4,0	3,5	38	24	0,3	3,0	0,05	645.00..D			424	424
R/L 055.4-28	4	1,5	4,0	3,5	42	28	0,3	3,0	0,05	645.00..D			428	428
R/L 055.5-10	5	1,9	5,0	4,4	25	10	0,5	3,8	0,05	645.00..D			510	510
R/L 055.5-15	5	1,9	5,0	4,4	30	15	0,5	3,8	0,05	645.00..D			515	515
R/L 055.5-20	5	1,9	5,0	4,4	35	20	0,5	3,8	0,05	645.00..D			520	520
R/L 055.5-25	5	1,9	5,0	4,4	40	25	0,5	3,8	0,05	645.00..D			525	525
R/L 055.5-30	5	1,9	5,0	4,4	45	30	0,5	3,8	0,05	645.00..D			530	530
R/L 055.5-35	5	1,9	5,0	4,4	50	35	0,5	3,8	0,05	645.00..D			535	535
R/L 055.6-15	6	2,3	6,0	5,3	30	15	0,5	4,5	0,05	676.00..D			615	615
R/L 055.6-22	6	2,3	6,0	5,3	37	22	0,5	4,5	0,05	676.00..D			622	622
R/L 055.6-25	6	2,3	6,0	5,3	40	25	0,5	4,5	0,05	676.00..D			625	625
R/L 055.6-30	6	2,3	6,0	5,3	45	30	0,5	4,5	0,05	676.00..D			630	630
R/L 055.6-35	6	2,3	6,0	5,3	50	35	0,5	4,5	0,05	676.00..D			635	635
R/L 055.6-42	6	2,3	6,0	5,3	57	42	0,5	4,5	0,05	676.00..D			642	642
Steel											●	●	●	●
Stainless steel											●	●	●	●
Cast iron											●	●	●	●
Non ferrous metals											●	●	●	●
Heat resistant alloys											●	●	●	●
hardened materials											●	●	●	●

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UltraMini – Inserts for internal turning and profiling

▲ with chip former



Illustrations show right-hand versions



Left-hand

Right-hand

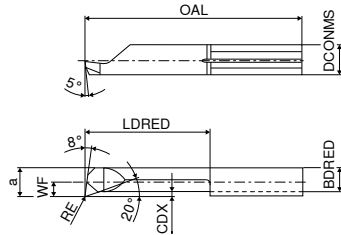
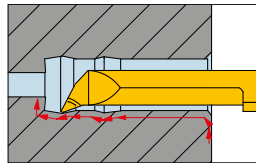
Designation	DCONMS ₁₆	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	mm	mm	mm		Article no. 73 017 ...	Article no. 73 016 ...
R/L 050.4-10C	4	1,5	4	3,5	24	10	0,3	3,0	0,2	645.00..-D	410	410
R/L 050.4-16C	4	1,5	4	3,5	30	16	0,3	3,0	0,2	645.00..-D	416	416
R/L 050.4-20C	4	1,5	4	3,5	34	20	0,3	3,0	0,2	645.00..-D	420	420
R/L 050.4-24C	4	1,5	4	3,5	38	24	0,3	3,0	0,2	645.00..-D	424	424
R/L 050.4-28C	4	1,5	4	3,5	42	28	0,3	3,0	0,2	645.00..-D	428	428
R/L 050.5-10C	5	1,9	5	4,4	25	10	0,5	3,8	0,2	645.00..-D	510	510
R/L 050.5-15C	5	1,9	5	4,4	30	15	0,5	3,8	0,2	645.00..-D	515	515
R/L 050.5-20C	5	1,9	5	4,4	35	20	0,5	3,8	0,2	645.00..-D	520	520
R/L 050.5-25C	5	1,9	5	4,4	40	25	0,5	3,8	0,2	645.00..-D	525	525
R/L 050.5-30C	5	1,9	5	4,4	45	30	0,5	3,8	0,2	645.00..-D	530	530
R/L 050.5-35C	5	1,9	5	4,4	50	35	0,5	3,8	0,2	645.00..-D	535	535
R/L 050.6-15C	6	2,3	6	5,3	30	15	0,5	4,5	0,2	676.00..-D	615	615
R/L 050.6-22C	6	2,3	6	5,3	37	22	0,5	4,5	0,2	676.00..-D	622	622
R/L 050.6-25C	6	2,3	6	5,3	40	25	0,5	4,5	0,2	676.00..-D	625	625
R/L 050.6-30C	6	2,3	6	5,3	45	30	0,5	4,5	0,2	676.00..-D	630	630
R/L 050.6-35C	6	2,3	6	5,3	50	35	0,5	4,5	0,2	676.00..-D	635	635
R/L 050.6-42C	6	2,3	6	5,3	57	42	0,5	4,5	0,2	676.00..-D	642	642
R/L 050.7-20C	7	2,8	7	6,3	35	20	0,6	5,5	0,2	676.00..-D	720	720
R/L 050.7-25C	7	2,8	7	6,3	40	25	0,6	5,5	0,2	676.00..-D	725	725
R/L 050.7-30C	7	2,8	7	6,3	45	30	0,6	5,5	0,2	676.00..-D	730	730
R/L 050.7-35C	7	2,8	7	6,3	50	35	0,6	5,5	0,2	676.00..-D	735	735
R/L 050.7-40C	7	2,8	7	6,3	55	40	0,6	5,5	0,2	676.00..-D	740	740
R/L 050.7-45C	7	2,8	7	6,3	60	45	0,6	5,5	0,2	676.00..-D	745	745
R/L 050.7-50C	7	2,8	7	6,3	65	50	0,6	5,5	0,2	676.00..-D	750	750

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials		

→ v_c Page 60

UltraMini – Inserts for internal turning and profiling – hard turning

▲ 46 to 65 HRC



Illustrations show right-hand versions

TiAlN+

TiAlN+



Left-hand

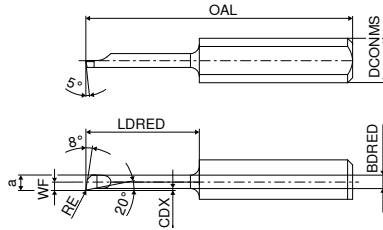
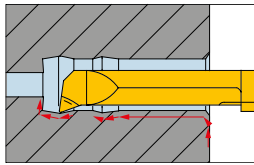
Right-hand

Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	mm	mm	mm		Article no. 73 025 ...	Article no. 73 024 ...
R/L 050.2-5	4		2,0	1,7	19	5	0,1	1,5	0,05	645.00..-D	920	920
R/L 050.2-10	4		2,0	1,7	24	10	0,1	1,5	0,05	645.00..-D	921	921
R/L 050.2-15	4		2,0	1,7	29	15	0,1	1,5	0,05	645.00..-D	922	922
R/L 050.3-10	4	0,6	2,8	2,6	24	10	0,2	2,3	0,10	645.00..-D	931	931
R/L 050.3-16	4	0,6	2,8	2,6	30	16	0,2	2,3	0,10	645.00..-D	930	930
R/L 050.3-20	4	0,6	2,8	2,6	34	20	0,2	2,3	0,10	645.00..-D	932	932
R/L 050.4-10	4	1,5	4,0	3,5	24	10	0,3	3,0	0,10	645.00..-D	941	941
R/L 050.4-16	4	1,5	4,0	3,5	30	16	0,3	3,0	0,10	645.00..-D	940	940
R/L 050.4-20	4	1,5	4,0	3,5	34	20	0,3	3,0	0,10	645.00..-D	942	942
R/L 050.4-24	4	1,5	4,0	3,5	38	24	0,3	3,0	0,10	645.00..-D	945	945
R/L 050.4-28	4	1,5	4,0	3,5	42	28	0,3	3,0	0,10	645.00..-D	946	946
R/L 050.5-10	5	1,9	5,0	4,4	25	10	0,5	3,8	0,15	645.00..-D	951	951
R/L 050.5-15	5	1,9	5,0	4,4	30	15	0,5	3,8	0,15	645.00..-D	952	952
R/L 050.5-20	5	1,9	5,0	4,4	35	20	0,5	3,8	0,15	645.00..-D	950	950
R/L 050.5-25	5	1,9	5,0	4,4	40	25	0,5	3,8	0,15	645.00..-D	953	953
R/L 050.5-30	5	1,9	5,0	4,4	45	30	0,5	3,8	0,15	645.00..-D	954	954
R/L 050.5-35	5	1,9	5,0	4,4	50	35	0,5	3,8	0,15	645.00..-D	956	956
R/L 050.6-15	6	2,3	6,0	5,3	30	15	0,5	4,5	0,15	676.00..-D	961	961
R/L 050.6-22	6	2,3	6,0	5,3	37	22	0,5	4,5	0,15	676.00..-D	960	960
R/L 050.6-25	6	2,3	6,0	5,3	40	25	0,5	4,5	0,15	676.00..-D	962	962
R/L 050.6-30	6	2,3	6,0	5,3	45	30	0,5	4,5	0,15	676.00..-D	963	963
R/L 050.6-35	6	2,3	6,0	5,3	50	35	0,5	4,5	0,15	676.00..-D	964	964
R/L 050.6-42	6	2,3	6,0	5,3	57	42	0,5	4,5	0,15	676.00..-D	965	965
R/L 050.7-20	7	2,8	6,8	6,3	35	20	0,6	5,5	0,15	676.00..-D	972	972
R/L 050.7-25	7	2,8	6,8	6,3	40	25	0,6	5,5	0,15	676.00..-D	973	973
R/L 050.7-30	7	2,8	6,8	6,3	45	30	0,6	5,5	0,15	676.00..-D	974	974
R/L 050.7-35	7	2,8	6,8	6,3	50	35	0,6	5,5	0,15	676.00..-D	975	975
R/L 050.7-40	7	2,8	6,8	6,3	55	40	0,6	5,5	0,15	676.00..-D	976	976
R/L 050.7-45	7	2,8	6,8	6,3	60	45	0,6	5,5	0,15	676.00..-D	977	977
R/L 050.7-50	7	2,8	6,8	6,3	65	50	0,6	5,5	0,15	676.00..-D	978	978

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials	●	●

UltraMini – Inserts for internal turning and profiling

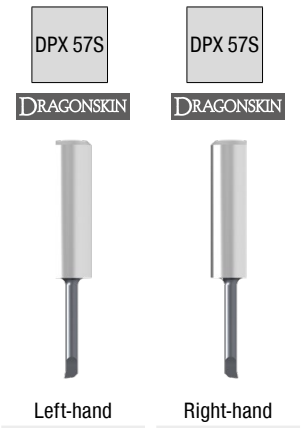
▲ Specially designed for super alloys



Illustrations show right-hand versions

Designation	DCONMS ₁₆	WF	DMIN		OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand		Right-hand	
	mm	mm	mm	mm							a	mm	mm	mm
R/L M050.05-2	4	0,20	0,5	0,40	20	2	0,02	0,02	0,02	645.00..-D	052	052		
R/L M050.08-4	4	0,35	0,8	0,70	20	4	0,08	0,03	0,02	645.00..-D	082	082		
R/L M050.1-5	4	0,40	1,0	0,90	20	5	0,05	0,05	0,02	645.00..-D	102	102		
R/L M050.1-7	4	0,40	1,0	0,90	22	7	0,05	0,05	0,02	645.00..-D	103	103		
R/L M050.15-5	4	0,60	1,5	1,15	19	5	0,08	0,08	0,02	645.00..-D	151	151		
R/L M050.15-10	4	0,60	1,5	1,15	24	10	0,08	0,08	0,02	645.00..-D	154	154		
R/L M050.2-5	4	0,80	2,0	1,70	19	5	0,08	0,08	0,02	645.00..-D	201	201		
R/L M050.2-10	4	0,80	2,0	1,70	24	10	0,08	0,08	0,02	645.00..-D	204	204		
R/L M050.25-5	4	0,20	2,5	2,20	19	5	0,10	0,10	0,02	645.00..-D	251	251		
R/L M050.25-10	4	0,20	2,5	2,20	24	10	0,10	0,10	0,02	645.00..-D	254	254		
R/L M050.3-10	4	0,60	3,0	2,60	24	10	0,15	0,15	0,02	645.00..-D	304	304		
R/L M050.3-16	4	0,60	3,0	2,60	30	16	0,15	0,15	0,02	645.00..-D	307	307		
R/L M050.35-10	4	1,10	3,5	3,10	24	10	0,17	0,17	0,02	645.00..-D	350	350		
R/L M050.35-16	4	1,10	3,5	3,10	30	16	0,17	0,17	0,02	645.00..-D	353	353		
R/L M050.35-20	4	1,10	3,5	3,10	34	20	0,17	0,17	0,02	645.00..-D	354	354		
R/L M050.4-10	4	1,50	4,0	3,50	24	10	0,20	0,20	0,02	645.00..-D	400	400		
R/L M050.4-16	4	1,50	4,0	3,50	30	16	0,20	0,20	0,02	645.00..-D	403	403		
R/L M050.4-20	4	1,50	4,0	3,50	34	20	0,20	0,20	0,02	645.00..-D	404	404		
R/L M050.4-24	4	1,50	4,0	3,50	38	24	0,20	0,20	0,02	645.00..-D	406	406		

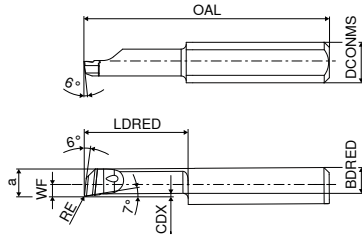
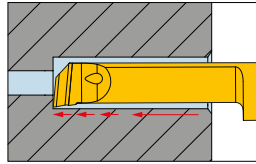
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		



→ v_c Page 60

UltraMini – Inserts for internal turning

▲ with chip former



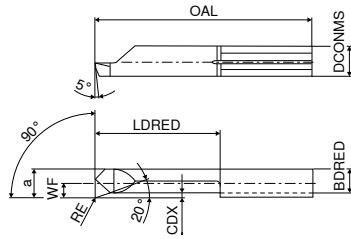
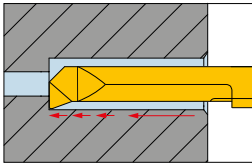
Illustrations show right-hand versions



Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRD	RE	Standard tool holder	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	mm	mm	mm		Article no. 73 001 ...	Article no. 73 000 ...
R/L X050.1-5	4		1,0	0,90	20	5	0,03	0,85	0,05	645.00..-D	121	121
R/L X050.15-7	4		1,5	1,35	22	7	0,05	1,25	0,10	645.00..-D	233	233
R/L X050.2-5	4		2,0	1,80	19	5	0,10	1,60	0,15	645.00..-D	245	245
R/L X050.2-10	4		2,0	1,80	24	10	0,10	1,60	0,05	645.00..-D	215	215
R/L X050.2-10	4		2,0	1,80	24	10	0,10	1,60	0,15	645.00..-D	241	241
R/L X050.3-10	4	0,7	3,0	2,70	24	10	0,15	2,55	0,05	645.00..-D	341	341
R/L X050.3-10	4	0,7	3,0	2,70	24	10	0,15	2,55	0,20	645.00..-D	347	347
R/L X050.3-16	4	0,7	3,0	2,70	30	16	0,15	2,55	0,05	645.00..-D	371	371
R/L X050.3-16	4	0,7	3,0	2,70	30	16	0,15	2,55	0,10	645.00..-D	373	373
R/L X050.3-16	4	0,7	3,0	2,70	30	16	0,15	2,55	0,20	645.00..-D	377	377
R/L X050.4-10	4	1,6	4,0	3,60	24	10	0,20	3,20	0,10	645.00..-D	403	403
R/L X050.4-10	4	1,6	4,0	3,60	24	10	0,20	3,20	0,20	645.00..-D	407	407
R/L X050.4-16	4	1,6	4,0	3,60	30	16	0,20	3,20	0,05	645.00..-D	431	431
R/L X050.4-16	4	1,6	4,0	3,60	30	16	0,20	3,20	0,10	645.00..-D	433	433
R/L X050.4-16	4	1,6	4,0	3,60	30	16	0,20	3,20	0,20	645.00..-D	437	437
R/L X050.4-24	4	1,6	4,0	3,60	38	24	0,20	3,20	0,10	645.00..-D	463	463
R/L X050.4-24	4	1,6	4,0	3,60	38	24	0,20	3,20	0,20	645.00..-D	467	467
R/L X050.5-15	5	2,1	5,0	4,60	30	15	0,30	4,05	0,05	645.00..-D	511	511
R/L X050.5-15	5	2,1	5,0	4,60	30	15	0,30	4,05	0,10	645.00..-D	513	513
R/L X050.5-15	5	2,1	5,0	4,60	30	15	0,30	4,05	0,20	645.00..-D	517	517
R/L X050.5-25	5	2,1	5,0	4,60	40	25	0,30	4,05	0,10	645.00..-D	543	543
R/L X050.5-25	5	2,1	5,0	4,60	40	25	0,30	4,05	0,20	645.00..-D	547	547
R/L X050.5-30	5	2,1	5,0	4,60	45	30	0,30	4,05	0,10	645.00..-D	553	553
R/L X050.5-30	5	2,1	5,0	4,60	45	30	0,30	4,05	0,20	645.00..-D	557	557
R/L X050.6-15	6	2,5	6,0	5,50	30	15	0,40	4,90	0,05	676.00..-D	611	611
R/L X050.6-15	6	2,5	6,0	5,50	30	15	0,40	4,90	0,10	676.00..-D	613	613
R/L X050.6-15	6	2,5	6,0	5,50	30	15	0,40	4,90	0,20	676.00..-D	617	617
R/L X050.6-22	6	2,5	6,0	5,50	37	22	0,40	4,90	0,20	676.00..-D	637	637
R/L X050.6-30	6	2,5	6,0	5,50	45	30	0,40	4,90	0,20	676.00..-D	657	657
R/L X050.6-35	6	2,5	6,0	5,50	50	35	0,40	4,90	0,20	676.00..-D	667	667
R/L X050.6-50	6	2,5	6,0	5,50	65	50	0,40	4,90	0,20	676.00..-D	697	697
R/L X050.7-25	7	3,0	7,0	6,50	40	25	0,50	5,90	0,20	676.00..-D	747	747
R/L X050.7-30	7	3,0	7,0	6,50	45	30	0,50	5,90	0,20	676.00..-D	757	757

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials	●	●

UltraMini – Inserts for internal turning



Illustrations show right-hand versions

Left-hand

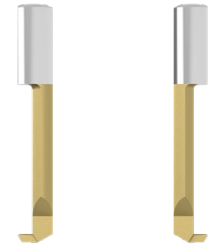
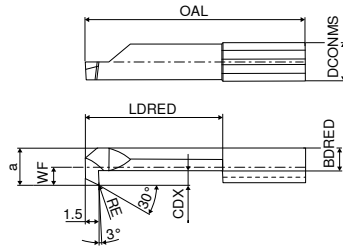
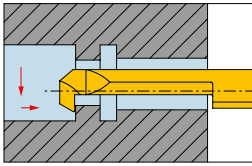
Right-hand

Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Article no. 73 015 ...	Article no. 73 014 ...
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
R/L 090.3-10	4	0,6	2,8	2,6	24	10	0,2	2,3	0,2	645.00..-D	541	541
R/L 090.3-16	4	0,6	2,8	2,6	30	16	0,2	2,3	0,2	645.00..-D	542	542
R/L 090.4-10	4	1,5	4,0	3,5	24	10	0,3	3,0	0,2	645.00..-D	545	545
R/L 090.4-16	4	1,5	4,0	3,5	30	16	0,3	3,0	0,2	645.00..-D	546	546
R/L 090.5-10	5	1,9	5,0	4,4	25	10	0,5	3,8	0,2	645.00..-D	550	550
R/L 090.5-15	5	1,9	5,0	4,4	30	15	0,5	3,8	0,2	645.00..-D	551	551
R/L 090.5-20	5	1,9	5,0	4,4	35	20	0,5	3,8	0,2	645.00..-D	552	552

Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

→ v_c Page 60

UltraMini – Inserts for back boring

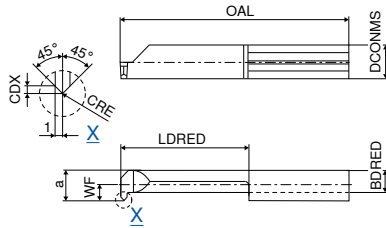
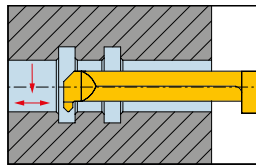


Illustrations show right-hand versions

Left-hand Right-hand

Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Article no. 73 013 ...	Article no. 73 012 ...
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
R/L 080.0003-15	4	0,6	3	2,6	29	15	0,5	2,0	0,10	645.00..-D	542	542
R/L 080.0003-20	4	0,6	3	2,6	34	20	0,5	2,0	0,10	645.00..-D	544	544
R/L 080.0004-15	4	1,5	4	3,5	29	15	0,8	2,4	0,15	645.00..-D	546	546
R/L 080.0004-25	4	1,5	4	3,5	39	25	0,8	2,4	0,15	645.00..-D	548	548
R/L 080.0005-20	5	1,9	5	4,4	35	20	1,0	3,3	0,20	645.00..-D	554	554
R/L 080.0005-30	5	1,9	5	4,4	45	30	1,0	3,3	0,20	645.00..-D	558	558
R/L 080.0006-20	6	2,3	6	5,3	35	20	1,8	3,4	0,20	676.00..-D	564	564
R/L 080.0006-30	6	2,3	6	5,3	45	30	1,8	3,4	0,20	676.00..-D	568	568
R/L 080.0007-20	7	2,7	7	6,3	35	20	2,5	3,8	0,20	676.00..-D	574	574
R/L 080.0007-30	7	2,7	7	6,3	45	30	2,5	3,8	0,20	676.00..-D	578	578
Steel											●	●
Stainless steel											●	●
Cast iron											○	○
Non ferrous metals											○	○
Heat resistant alloys											○	○
hardened materials											○	○

UltraMini – Inserts for internal turning and chamfering



Illustrations show right-hand versions



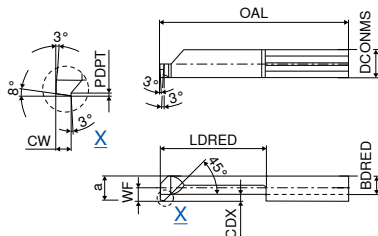
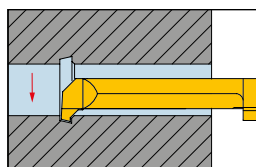
Left-hand

Right-hand

Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRD	CRE	Standard tool holder	Article no.	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		73 007 ...	73 006 ...
R/L 060.5-15	5	1,9	5,0	4,4	30	15	0,7	3,3	0,2	645.00..-D	551	551
R/L 060.5-20	5	1,9	5,0	4,4	35	20	0,7	3,3	0,2	645.00..-D	550	550
R/L 060.7-20	7	2,7	6,8	6,3	35	20	0,7	3,8	0,2	676.00..-D	570	570
Steel											●	●
Stainless steel											●	●
Cast iron											○	○
Non ferrous metals											○	○
Heat resistant alloys											○	○
hardened materials											○	○

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UltraMini – Inserts for internal chamfering for subsequent parting off



Illustrations show right-hand versions



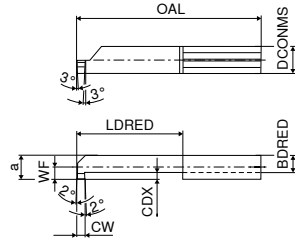
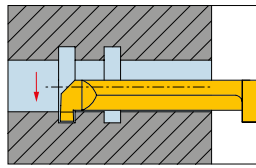
Left-hand

Right-hand

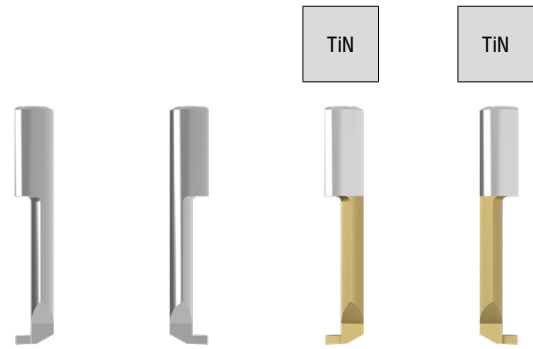
Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRD	CW	PDPT	Standard tool holder	Article no.	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		73 009 ...	73 008 ...
R/L 070.4-10	4	1,5	4	3,5	25	10	0,8	2,4	1	0,2	645.00..-D	410	410
R/L 070.4-16	4	1,5	4	3,5	30	16	0,8	2,4	1	0,2	645.00..-D	416	416
R/L 070.5-15	5	1,9	5	4,4	30	15	1,0	3,3	1	0,2	645.00..-D	551	551
R/L 070.5-20	5	1,9	5	4,4	35	20	1,0	3,3	1	0,2	645.00..-D	550	550
R/L 070.5-30	5	1,9	5	4,4	45	30	1,0	3,3	1	0,2	645.00..-D	530	530
R/L 070.6-30	6	2,3	6	5,3	45	30	1,0	4,2	1	0,2	676.00..-D	630	630
R/L 070.6-42	6	2,3	6	5,3	57	42	1,0	4,2	1	0,2	676.00..-D	642	642
Steel												●	●
Stainless steel												●	●
Cast iron												○	○
Non ferrous metals												○	○
Heat resistant alloys												○	○
hardened materials												○	○

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UltraMini – Inserts for Internal Grooving



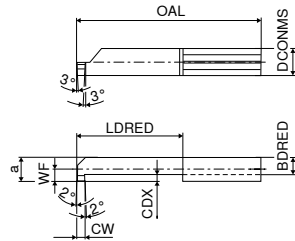
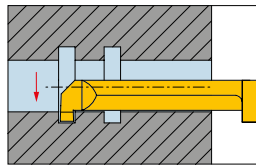
Illustrations show right-hand versions



Designation	DCONMS _{ns} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand
											Article no. 73 003 ...	Article no. 73 002 ...	Article no. 73 003 ...	Article no. 73 002 ...
R/L 004.0100-10	4	1,5	4,0	3,5	24	10	0,8	2,4	1,0	645.00.-D	040			
R/L 004.0100-16	4	1,5	4,0	3,5	30	16	0,8	2,4	1,0	645.00.-D	041			540
R/L 004.0100-20	4	1,5	4,0	3,5	34	20	0,8	2,4	1,0	645.00.-D	042			541
R/L 004.0100-20	4	1,5	4,0	3,5	34	20	0,8	2,4	1,0	645.00.-D				542
R/L 005.0100-10	5	1,9	5,0	4,4	25	10	1,0	3,3	1,0	645.00.-D	150			650
R/L 005.0150-10	5	1,9	5,0	4,4	25	10	1,0	3,3	1,5	645.00.-D	154			654
R/L 005.0200-10	5	1,9	5,0	4,4	25	10	1,0	3,3	2,0	645.00.-D	158			658
R/L 005.0100-15	5	1,9	5,0	4,4	30	15	1,0	3,3	1,0	645.00.-D	151			651
R/L 005.0150-15	5	1,9	5,0	4,4	30	15	1,0	3,3	1,5	645.00.-D	155			655
R/L 005.0200-15	5	1,9	5,0	4,4	30	15	1,0	3,3	2,0	645.00.-D	159			659
R/L 005.0100-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,0	645.00.-D	051			551
R/L 005.0150-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,5	645.00.-D	052			552
R/L 005.0200-20	5	1,9	5,0	4,4	35	20	1,0	3,3	2,0	645.00.-D	053			553
R/L 005.0100-25	5	1,9	5,0	4,4	40	25	1,0	3,3	1,0	645.00.-D	152			652
R/L 005.0150-25	5	1,9	5,0	4,4	40	25	1,0	3,3	1,5	645.00.-D	156			656
R/L 005.0200-25	5	1,9	5,0	4,4	40	25	1,0	3,3	2,0	645.00.-D	250			750
R/L 005.0100-30	5	1,9	5,0	4,4	45	30	1,0	3,3	1,0	645.00.-D	153			653
R/L 005.0150-30	5	1,9	5,0	4,4	45	30	1,0	3,3	1,5	645.00.-D	157			657
R/L 005.0200-30	5	1,9	5,0	4,4	45	30	1,0	3,3	2,0	645.00.-D	251			751
R/L 005.0100-35	5	1,9	5,0	4,4	50	35	1,0	3,3	1,0	645.00.-D				680
R/L 005.0100-35	5	1,9	5,0	4,4	50	35	1,0	3,3	1,0	645.00.-D				680
R/L 006.0100-10	6	2,3	6,0	5,3	25	10	1,8	3,4	1,0	676.00.-D	160			660
R/L 006.0150-10	6	2,3	6,0	5,3	25	10	1,8	3,4	1,5	676.00.-D	164			664
R/L 006.0200-10	6	2,3	6,0	5,3	25	10	1,8	3,4	2,0	676.00.-D	168			668
R/L 006.0100-15	6	2,3	6,0	5,3	30	15	1,8	3,4	1,0	676.00.-D	161			661
R/L 006.0150-15	6	2,3	6,0	5,3	30	15	1,8	3,4	1,5	676.00.-D	165			665
R/L 006.0200-15	6	2,3	6,0	5,3	30	15	1,8	3,4	2,0	676.00.-D	169			669
R/L 006.0100-22	6	2,3	6,0	5,3	37	22	1,8	3,4	1,0	676.00.-D	061			561
R/L 006.0150-22	6	2,3	6,0	5,3	37	22	1,8	3,4	1,5	676.00.-D	062			562
R/L 006.0200-22	6	2,3	6,0	5,3	37	22	1,8	3,4	2,0	676.00.-D	063			563
R/L 006.0100-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,0	676.00.-D	162			662
R/L 006.0150-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,5	676.00.-D	166			666
R/L 006.0200-25	6	2,3	6,0	5,3	40	25	1,8	3,4	2,0	676.00.-D	260			760
R/L 006.0100-30	6	2,3	6,0	5,3	45	30	1,8	3,4	1,0	676.00.-D	163			663
R/L 006.0150-30	6	2,3	6,0	5,3	45	30	1,8	3,4	1,5	676.00.-D	167			667
R/L 006.0200-30	6	2,3	6,0	5,3	45	30	1,8	3,4	2,0	676.00.-D	261			761
R/L 006.0100-35	6	2,3	6,0	5,3	50	35	1,8	3,4	1,0	676.00.-D				682
R/L 006.0150-35	6	2,3	6,0	5,3	50	35	1,8	3,4	1,5	676.00.-D				684
R/L 006.0100-42	6	2,3	6,0	5,3	57	42	1,8	3,4	1,0	676.00.-D				685
R/L 006.0100-42	6	2,3	6,0	5,3	57	42	1,8	3,4	1,0	676.00.-D				685
R/L 007.0100-10	7	2,7	6,8	6,3	25	10	2,5	3,8	1,0	676.00.-D	070			570
R/L 007.0150-10	7	2,7	6,8	6,3	25	10	2,5	3,8	1,5	676.00.-D	075			575
R/L 007.0200-10	7	2,7	6,8	6,3	25	10	2,5	3,8	2,0	676.00.-D	170			670
R/L 007.0100-15	7	2,7	6,8	6,3	30	15	2,5	3,8	1,0	676.00.-D	071			571
R/L 007.0150-15	7	2,7	6,8	6,3	30	15	2,5	3,8	1,5	676.00.-D	076			576
R/L 007.0200-15	7	2,7	6,8	6,3	30	15	2,5	3,8	2,0	676.00.-D	171			671
R/L 007.0100-22	7	2,7	6,8	6,3	37	22	2,5	3,8	1,0	676.00.-D	072			572
R/L 007.0150-22	7	2,7	6,8	6,3	37	22	2,5	3,8	1,5	676.00.-D	077			577
R/L 007.0200-22	7	2,7	6,8	6,3	37	22	2,5	3,8	2,0	676.00.-D	172			672
R/L 007.0100-25	7	2,7	6,8	6,3	40	25	2,5	3,8	1,0	676.00.-D	073			573
R/L 007.0150-25	7	2,7	6,8	6,3	40	25	2,5	3,8	1,5	676.00.-D	078			578
R/L 007.0200-25	7	2,7	6,8	6,3	40	25	2,5	3,8	2,0	676.00.-D	173			673
R/L 007.0100-30	7	2,7	6,8	6,3	45	30	2,5	3,8	1,0	676.00.-D	074			574
R/L 007.0150-30	7	2,7	6,8	6,3	45	30	2,5	3,8	1,5	676.00.-D	079			579
R/L 007.0200-30	7	2,7	6,8	6,3	45	30	2,5	3,8	2,0	676.00.-D	174			674
R/L 007.0100-35	7	2,7	7,0	6,3	50	35	2,5	3,8	1,0	676.00.-D				688
R/L 007.0150-35	7	2,7	7,0	6,3	50	35	2,5	3,8	1,5	676.00.-D				690
R/L 007.0200-35	7	2,7	7,0	6,3	50	35	2,5	3,8	2,0	676.00.-D				692
R/L 007.0100-40	7	2,7	7,0	6,3	55	40	2,5	3,8	1,0	676.00.-D				700
R/L 007.0150-40	7	2,7	7,0	6,3	55	40	2,5	3,8	1,5	676.00.-D				702
R/L 007.0100-45	7	2,7	7,0	6,3	60	45	2,5	3,8	1,0	676.00.-D				712
R/L 007.0100-50	7	2,7	7,0	6,3	65	50	2,5	3,8	1,0	676.00.-D				714

Steel	○	○	●	●
Stainless steel			●	●
Cast iron	○	○	○	○
Non ferrous metals	●	●	○	○
Heat resistant alloys			○	○
hardened materials				

UltraMini – Inserts for Internal Grooving



Illustrations show right-hand versions

TiAlN

TiAlN



Left-hand

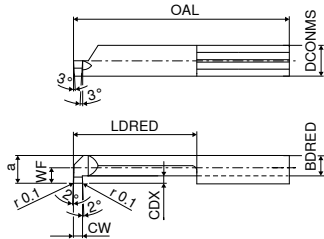
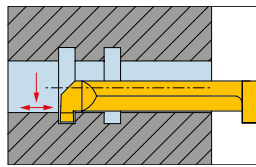
Right-hand

Designation	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CW	Standard tool holder	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	mm	mm	mm		Article no. 73 003 ...	Article no. 73 002 ...
R/L 002.0050-5	4		2	1,8	19	5	0,4	1,2	0,5	645.00..-D	820	820
R/L 002.0050-10	4		2	1,8	24	10	0,4	1,2	0,5	645.00..-D	821	821
R/L 002.0050-15	4		2	1,8	29	15	0,4	1,2	0,5	645.00..-D	822	822
R/L 003.0070-5	4	0,7	3	2,7	19	5	0,6	1,9	0,7	645.00..-D	830	830
R/L 003.0070-10	4	0,7	3	2,7	24	10	0,6	1,9	0,7	645.00..-D	831	831
R/L 003.0070-16	4	0,7	3	2,7	30	16	0,6	1,9	0,7	645.00..-D	832	832
Steel											●	●
Stainless steel											●	●
Cast iron											●	●
Non ferrous metals											●	●
Heat resistant alloys											●	●
hardened materials												

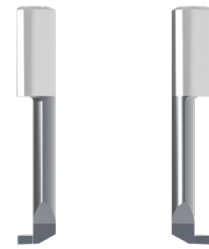
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UltraMini – Inserts for Internal Grooving

▲ with corner radius



Illustrations show right-hand versions



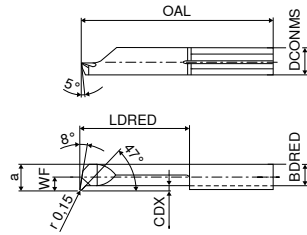
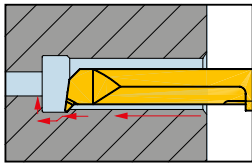
Left-hand

Right-hand

Designation	DCONMS _{ns} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRD mm	CW mm	Standard tool holder	Article no.	
											73 203 ...	73 202 ...
R/L 004M0100-10	4	1,5	4,0	3,5	24	10	0,8	2,4	1,0	645.00..-D	800	800
R/L 004M0100-16	4	1,5	4,0	3,5	30	16	0,8	2,4	1,0	645.00..-D	802	802
R/L 004M0100-20	4	1,5	4,0	3,5	34	20	0,8	2,4	1,0	645.00..-D	804	804
R/L 005M0100-10	5	1,9	5,0	4,4	25	10	1,0	3,3	1,0	645.00..-D	806	806
R/L 005M0150-10	5	1,9	5,0	4,4	25	10	1,0	3,3	1,5	645.00..-D	816	816
R/L 005M0200-10	5	1,9	5,0	4,4	25	10	1,0	3,3	2,0	645.00..-D	826	826
R/L 005M0100-15	5	1,9	5,0	4,4	30	15	1,0	3,3	1,0	645.00..-D	808	808
R/L 005M0150-15	5	1,9	5,0	4,4	30	15	1,0	3,3	1,5	645.00..-D	818	818
R/L 005M0200-15	5	1,9	5,0	4,4	30	15	1,0	3,3	2,0	645.00..-D	828	828
R/L 005M0100-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,0	645.00..-D	810	810
R/L 005M0150-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,5	645.00..-D	820	820
R/L 005M0200-20	5	1,9	5,0	4,4	35	20	1,0	3,3	2,0	645.00..-D	830	830
R/L 005M0100-25	5	1,9	5,0	4,4	40	25	1,0	3,3	1,0	645.00..-D	812	812
R/L 005M0150-25	5	1,9	5,0	4,4	40	25	1,0	3,3	1,5	645.00..-D	822	822
R/L 005M0200-25	5	1,9	5,0	4,4	40	25	1,0	3,3	2,0	645.00..-D	832	832
R/L 005M0100-30	5	1,9	5,0	4,4	45	30	1,0	3,3	1,0	645.00..-D	814	814
R/L 005M0150-30	5	1,9	5,0	4,4	45	30	1,0	3,3	1,5	645.00..-D	824	824
R/L 005M0200-30	5	1,9	5,0	4,4	45	30	1,0	3,3	2,0	645.00..-D	834	834
R/L 006M0100-10	6	2,3	6,0	5,3	25	10	1,8	3,4	1,0	676.00..-D	836	836
R/L 006M0150-10	6	2,3	6,0	5,3	25	10	1,8	3,4	1,5	676.00..-D	846	846
R/L 006M0200-10	6	2,3	6,0	5,3	25	10	1,8	3,4	2,0	676.00..-D	856	856
R/L 006M0100-15	6	2,3	6,0	5,3	30	15	1,8	3,4	1,0	676.00..-D	838	838
R/L 006M0150-15	6	2,3	6,0	5,3	30	15	1,8	3,4	1,5	676.00..-D	848	848
R/L 006M0200-15	6	2,3	6,0	5,3	30	15	1,8	3,4	2,0	676.00..-D	858	858
R/L 006M0100-20	6	2,3	6,0	5,3	35	22	1,8	3,4	1,0	676.00..-D	840	840
R/L 006M0150-20	6	2,3	6,0	5,3	37	22	1,8	3,4	1,5	676.00..-D	850	850
R/L 006M0200-20	6	2,3	6,0	5,3	37	22	1,8	3,4	2,0	676.00..-D	860	860
R/L 006M0100-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,0	676.00..-D	842	842
R/L 006M0150-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,5	676.00..-D	852	852
R/L 006M0200-25	6	2,3	6,0	5,3	40	25	1,8	3,4	2,0	676.00..-D	862	862
R/L 006M0100-30	6	2,3	6,0	5,3	45	30	1,8	3,4	1,0	676.00..-D	844	844
R/L 006M0150-30	6	2,3	6,0	5,3	45	30	1,8	3,4	1,5	676.00..-D	854	854
R/L 006M0200-30	6	2,3	6,0	5,3	45	30	1,8	3,4	2,0	676.00..-D	864	864
R/L 007M0100-10	7	2,7	6,8	6,3	25	10	2,5	3,7	1,0	676.00..-D	866	866
R/L 007M0150-10	7	2,7	6,8	6,3	25	10	2,5	3,7	1,5	676.00..-D	876	876
R/L 007M0200-10	7	2,7	6,8	6,3	25	10	2,5	3,7	2,0	676.00..-D	886	886
R/L 007M0100-15	7	2,7	6,8	6,3	30	15	2,5	3,7	1,0	676.00..-D	868	868
R/L 007M0150-15	7	2,7	6,8	6,3	30	15	2,5	3,7	1,5	676.00..-D	878	878
R/L 007M0200-15	7	2,7	6,8	6,3	30	15	2,5	3,7	2,0	676.00..-D	888	888
R/L 007M0100-22	7	2,7	6,8	6,3	37	22	2,5	3,7	1,0	676.00..-D	870	870
R/L 007M0150-22	7	2,7	6,8	6,3	37	22	2,5	3,7	1,5	676.00..-D	880	880
R/L 007M0200-22	7	2,7	6,8	6,3	37	22	2,5	3,7	2,0	676.00..-D	890	890
R/L 007M0100-25	7	2,7	6,8	6,3	40	25	2,5	3,7	1,0	676.00..-D	872	872
R/L 007M0150-25	7	2,7	6,8	6,3	40	25	2,5	3,7	1,5	676.00..-D	882	882
R/L 007M0200-25	7	2,7	6,8	6,3	40	25	2,5	3,7	2,0	676.00..-D	892	892
R/L 007M0100-30	7	2,7	6,8	6,3	45	30	2,5	3,7	1,0	676.00..-D	874	874
R/L 007M0150-30	7	2,7	6,8	6,3	45	30	2,5	3,7	1,5	676.00..-D	884	884
R/L 007M0200-30	7	2,7	6,8	6,3	45	30	2,5	3,7	2,0	676.00..-D	894	894

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials	●	●

UltraMini – Inserts for internal undercuts



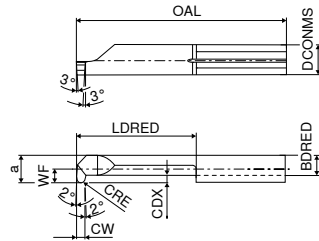
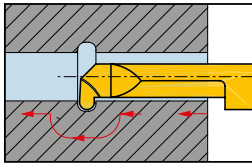
Illustrations show right-hand versions



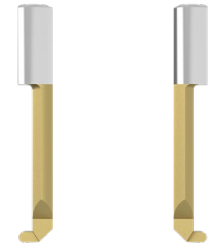
Designation	DCONMS _{h5} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand
										Article no. 73 011 ...	Article no. 73 010 ...	Article no. 73 011 ...	Article no. 73 010 ...
R/L 047.2-10	4		2,0	1,7	24	10	0,4	1,2	645.00.-D			221	221
R/L 047.3-15	4	0,6	2,8	2,6	29	15	0,6	1,9	645.00.-D			231	231
R/L 047.4-10	4	1,5	4,0	3,5	24	10	0,6	2,8	645.00.-D			241	241
R/L 047.T4-20	4	1,5	4,0	3,5	34	20	0,6	2,8	645.00.-D			242	242
R/L 047.4-20	4	1,5	4,0	3,5	34	20	0,3	3,0	645.00.-D	542	542		
R/L 047.5-15	5	1,9	5,0	4,4	30	15	0,8	3,5	645.00.-D			251	251
R/L 047.T5-25	5	1,9	5,0	4,4	40	25	0,8	3,5	645.00.-D			252	252
R/L 047.5-25	5	1,9	5,0	4,4	40	25	0,5	3,8	645.00.-D	552	552		
R/L 047.T6-22	6	2,3	6,0	5,3	37	22	1,8	3,4	676.00.-D			262	262
R/L 047.T6-30	6	2,3	6,0	5,3	45	30	1,8	3,4	676.00.-D			263	263
R/L 047.6-30	6	2,3	6,0	5,3	45	30	0,5	4,5	676.00.-D	562	562		
Steel										●	●	●	●
Stainless steel										●	●	●	●
Cast iron										○	○	●	●
Non ferrous metals										○	○	●	●
Heat resistant alloys										○	○	●	●
hardened materials													

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UltraMini – Inserts for internal grooving and turning



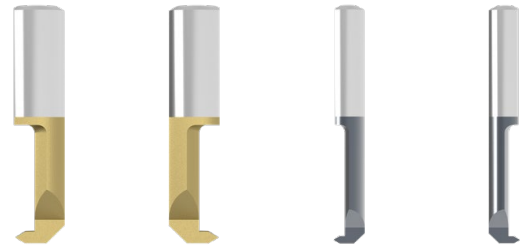
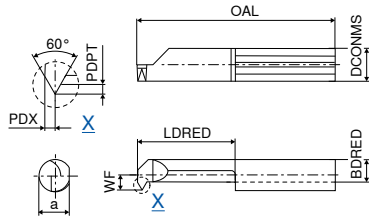
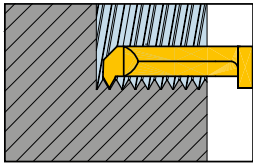
Illustrations show right-hand versions



Left-hand Right-hand

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	CRE mm	Standard tool holder	Article no.	
												73 019 ...	73 018 ...
R/L 006-0.75-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,5	0,75	676.00..-D	564	564
R/L 006-0.50-25	6	2,3	6,0	5,3	40	25	1,8	3,4	1,0	0,50	676.00..-D	562	562
R/L 006-1.00-25	6	2,3	6,0	5,3	40	25	1,8	3,4	2,0	1,00	676.00..-D	566	566
R/L 005-1.00-20	5	1,9	5,0	4,4	35	20	1,0	3,3	2,0	1,00	645.00..-D	556	556
R/L 007-0.50-30	7	2,7	6,8	6,3	45	30	2,5	3,8	1,0	0,50	676.00..-D	572	572
R/L 005-0.75-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,5	0,75	645.00..-D	554	554
R/L 007-0.75-30	7	2,7	6,8	6,3	45	30	2,5	3,8	1,5	0,75	676.00..-D	574	574
R/L 005-0.50-20	5	1,9	5,0	4,4	35	20	1,0	3,3	1,0	0,50	645.00..-D	552	552
R/L 007-1.00-30	7	2,7	6,8	6,3	45	30	2,5	3,8	2,0	1,00	676.00..-D	576	576
R/L 004-0.50-16	4	1,5	4,0	3,5	30	16	0,8	2,4	1,0	0,50	645.00..-D	541	541
Steel												●	●
Stainless steel												●	●
Cast iron												○	○
Non ferrous metals												○	○
Heat resistant alloys												○	○
hardened materials												○	○

UltraMini – Inserts for internal threading (Partial profile)



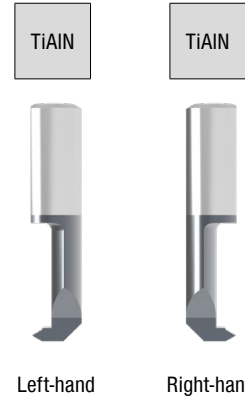
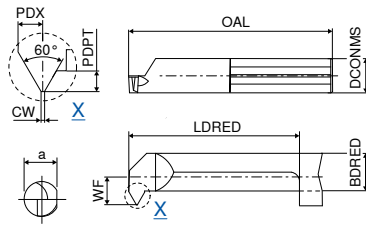
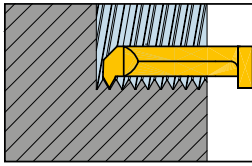
Left-hand Right-hand Left-hand Right-hand

Illustrations show right-hand versions

Designation	DCONMS _{ns} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	Standard tool holder	Article no.	Article no.	Article no.	Article no.
												73 101 ...	73 100 ...	73 101 ...	73 100 ...
R/L 003.0105-8	4	0,50	0,30	2,4	2,3	22	8	1,8	0,27	0,33	645.00..-D				
R/L 004.0408-15	4	0,80	1,75	4,0	3,5	30	15	2,4	0,43	0,45	645.00..-D			551	551
														552	552
R/L 005.0510-15	5	1,00	1,90	4,8	4,4	30	15	3,3	0,55	0,55	645.00..-D	545	545		
R/L 005.0510-20	5	1,00	1,90	4,8	4,4	35	20	3,3	0,55	0,55	645.00..-D	544	544		
R/L 006.0612-15	6	1,25	2,30	6,0	5,3	30	15	3,4	0,68	0,65	676.00..-D	547	547		
R/L 006.0612-22	6	1,25	2,30	6,0	5,3	37	22	3,4	0,68	0,65	676.00..-D	546	546		
R/L 006.0815-15	6	1,50	2,30	6,0	5,3	30	15	3,4	0,81	0,75	676.00..-D	549	549		
R/L 006.0815-22	6	1,50	2,30	6,0	5,3	37	22	3,4	0,81	0,75	676.00..-D	548	548		
R/L 007.0815-15	7	1,50	2,70	7,0	6,3	30	15	3,8	0,81	0,75	676.00..-D	550	550		
Steel												●	●	●	●
Stainless steel												●	●	●	●
Cast iron												○	○	○	○
Non ferrous metals												○	○	○	○
Heat resistant alloys												○	○	●	●
hardened materials												○	○	○	○

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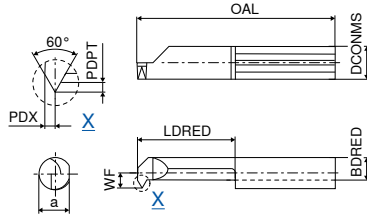
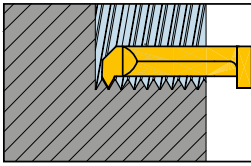
UltraMini – Inserts for Internal thread turning (Full profile)



Illustrations show right-hand versions

Designation	DCONMS _{hg} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	Standard tool holder	Article no.	Article no.
													73 209 ...	73 208 ...
R/L 105.0408-15	5	0,80	1,9	4,8	4,4	30	15	3,3	0,43	0,50	0,10	645.00..-D	799	799
R/L 105.510-15	5	1,00	1,9	4,8	4,4	30	15	3,3	0,54	0,55	0,12	645.00..-D	800	800
R/L 106.612-15	6	1,25	2,3	6,0	5,3	30	15	3,4	0,67	0,65	0,15	676.00..-D	802	802
R/L 106.815-15	6	1,50	2,3	6,0	5,3	30	15	3,4	0,81	0,75	0,18	676.00..-D	804	804
R/L 106.815-15	7	1,50	2,7	7,0	6,3	30	15	3,8	0,81	0,75	0,18	676.00..-D	806	806
Steel													•	•
Stainless steel													•	•
Cast iron													•	•
Non ferrous metals													•	•
Heat resistant alloys													•	•
hardened materials													•	•

UltraMini – Inserts for internal thread turning (Partial profile)



Left-hand Right-hand Left-hand Right-hand

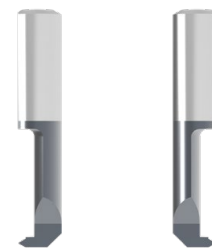
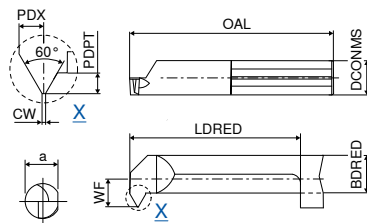
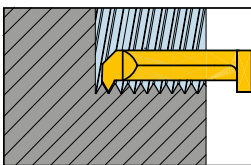
Illustrations show right-hand versions

Designation	DCONMS _{ns} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	Standard tool holder	Article no.	Article no.	Article no.	Article no.
												73 103 ...	73 102 ...	73 103 ...	73 102 ...
R/L 004.0105-10	4	0,50	1,0	3,2	3,0	24	10	2,3	0,27	0,44	645.00..-D				
R/L 004.0205-15	4	0,50	1,5	4,0	3,5	30	15	2,4	0,27	0,35	645.00..-D	510	510	509	509
R/L 005.0205-15	5	0,50	1,9	5,0	4,4	30	15	3,3	0,27	0,35	645.00..-D	539	539		
R/L 005.0205-20	5	0,50	1,9	5,0	4,4	35	20	3,3	0,27	0,35	645.00..-D	540	540		
R/L 005.0407-15	5	0,75	1,9	5,0	4,4	30	15	3,3	0,40	0,45	645.00..-D	541	541		
R/L 005.0407-20	5	0,75	1,9	5,0	4,4	35	20	3,3	0,40	0,45	645.00..-D	542	542		
R/L 006.0510-15	6	1,00	2,3	6,0	5,3	30	15	3,4	0,55	0,55	676.00..-D	543	543		
R/L 006.0510-22	6	1,00	2,3	6,0	5,3	37	22	3,4	0,55	0,55	676.00..-D	544	544		

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

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UltraMini – Inserts for Internal thread turning (Full profile)



Left-hand Right-hand

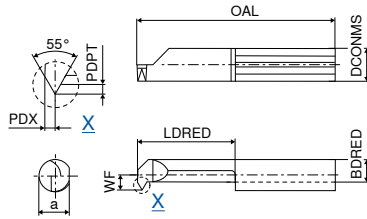
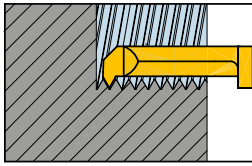
Illustrations show right-hand versions

Designation	DCONMS _{ns} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	Standard tool holder	Article no.	Article no.
													73 207 ...	73 206 ...
R/L 104.0205-15	5	0,50	1,5	4	3,5	30	15	2,4	0,27	0,35	0,06	645.00..-D	800	800
R/L 105.0205-15	5	0,50	1,9	5	4,4	30	15	3,3	0,27	0,35	0,06	645.00..-D	802	802
R/L 105.0407-15	5	0,75	1,9	5	4,4	30	15	3,3	0,40	0,45	0,09	645.00..-D	804	804
R/L 106.0510-15	6	1,00	2,3	6	5,3	30	15	3,4	0,54	0,55	0,12	676.00..-D	806	806

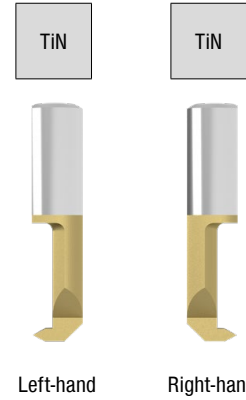
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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UltraMini – Inserts for internal thread turning (Partial profile)



Illustrations show right-hand versions

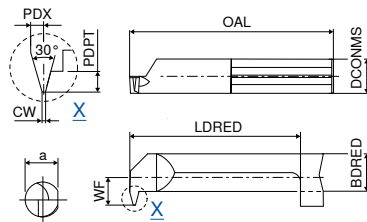
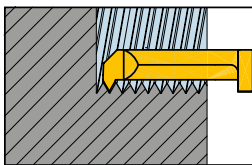


Designation	DCONMS _{h6} mm	TPI 1/"	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	Standard tool holder	Article no.	
												73 105 ...	73 104 ...
R/L 005.5548-15	5	48 - 24	1,9	4,8	4,4	30	15	3,3	0,40	0,45	645.00.-D	552	552
R/L 006.5548-15	6	48 - 24	2,3	6,0	5,3	30	15	3,4	0,40	0,45	676.00.-D	562	562
R/L 006.5524-15	6	24 - 16	2,3	6,0	5,3	30	15	3,4	0,81	0,75	676.00.-D	563	563
R/L 007.5524-15	7	24 - 16	2,7	7,0	6,3	30	15	3,8	0,81	0,75	676.00.-D	572	572
Steel												●	●
Stainless steel												●	●
Cast iron												○	○
Non ferrous metals												○	○
Heat resistant alloys												○	○
hardened materials												○	○

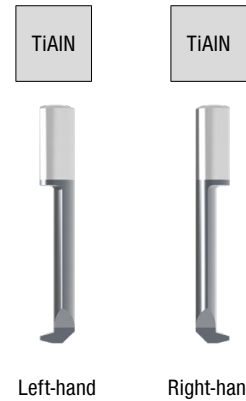
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UltraMini – Inserts for internal thread turning (Partial profile)

▲ Trapezoidal thread DIN 103



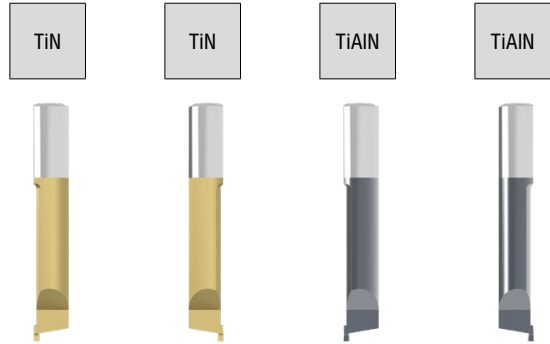
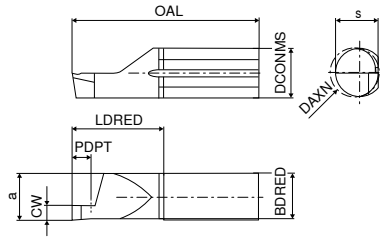
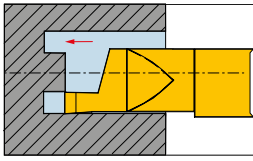
Illustrations show right-hand versions



Designation	DCONMS _{h6} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	Standard tool holder	Article no.	
													73 211 ...	73 210 ...
R/L 007.1220-22	7	2	2,8	7	6,3	37	22	3,8	1,25	0,75	0,6	676.00.-D	222	222
R/L 007.1220-30	7	2	2,8	7	6,3	45	30	3,8	1,25	0,75	0,6	676.00.-D	230	230
R/L 007.1730-22	7	3	2,8	7	6,3	37	22	3,8	1,75	1,10	1,0	676.00.-D	322	322
R/L 007.1730-30	7	3	2,8	7	6,3	45	30	3,8	1,75	1,10	1,0	676.00.-D	330	330
Steel													●	●
Stainless steel													●	●
Cast iron													●	●
Non ferrous metals													●	●
Heat resistant alloys													●	●
hardened materials													●	●

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UltraMini – Inserts for axial grooving



Illustrations show right-hand versions

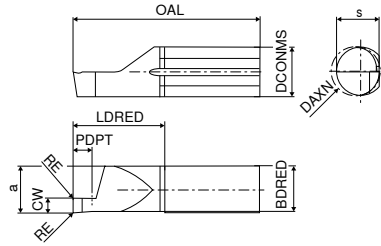
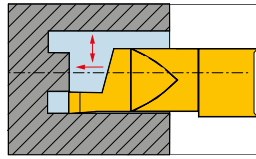
Designation	DCONMS _{NS} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand
											Article no. 73 051 ...	Article no. 73 050 ...	Article no. 73 053 ...	Article no. 73 052 ...
R/L 010.1006-10	6	5,2	6	5,3	26	11	1,5	4,9	1,0	676.00.-D	561	561	561	561
R/L 010.1506-10	6	5,2	6	5,3	26	11	2,0	4,9	1,5	676.00.-D	563	563	563	563
R/L 010.1008-10	7	5,9	8	6,3	26	11	1,5	5,6	1,0	676.00.-D	571	571	571	571
R/L 010.1008-20	7	5,9	8	6,3	35	20	1,5	5,6	1,0	676.00.-D	671	671	671	671
R/L 010.1008-30	7	5,9	8	6,3	45	30	1,5	5,6	1,0	676.00.-D	771	771	771	771
R/L 010.1508-10	7	5,9	8	6,3	26	11	2,5	5,6	1,5	676.00.-D	573	573	573	573
R/L 010.1508-20	7	5,9	8	6,3	35	20	2,5	5,6	1,5	676.00.-D	673	673	673	673
R/L 010.1508-30	7	5,9	8	6,3	45	30	2,5	5,6	1,5	676.00.-D	773	773	773	773
R/L 010.2008-10	7	5,9	8	6,3	26	11	3,0	5,6	2,0	676.00.-D	575	575	575	575
R/L 010.2008-20	7	5,9	8	6,3	35	20	3,0	5,6	2,0	676.00.-D	675	675	675	675
R/L 010.2008-30	7	5,9	8	6,3	45	30	3,0	5,6	2,0	676.00.-D	775	775	775	775
R/L 010.2508-10	7	5,9	8	6,3	26	11	3,5	5,6	2,5	676.00.-D	577	577	577	577
R/L 010.2508-20	7	5,9	8	6,3	35	20	3,5	5,6	2,5	676.00.-D	677	677	677	677
R/L 010.2508-30	7	5,9	8	6,3	45	30	3,5	5,6	2,5	676.00.-D	777	777	777	777
R/L 010.3008-10	7	5,9	8	6,3	26	11	3,5	5,6	3,0	676.00.-D	579	579	579	579
R/L 010.3008-20	7	5,9	8	6,3	35	20	3,5	5,6	3,0	676.00.-D	679	679	679	679
R/L 010.3008-30	7	5,9	8	6,3	45	30	3,5	5,6	3,0	676.00.-D	779	779	779	779

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

→ v_c Page 60

UltraMini – Inserts for axial grooving

▲ with corner radius



Illustrations show right-hand versions

TiAlN

TiAlN



Left-hand

Right-hand

Designation	DCONMS ₁₆	a	DAXN	s	OAL	LDRED	PDPT	BDRED	CW	RE	Standard tool holder	Article no.	
	mm											mm	mm
R/L 510M1008-10	5	4,3	5	6,3	26	11	2	4,0	1,0	0,05	645.00..-D	510	510
R/L 510M1008-20	5	4,3	5	6,3	35	20	2	4,0	1,0	0,05	645.00..-D	610	610
R/L 510M1508-10	5	4,3	5	6,3	26	11	3	4,0	1,5	0,05	645.00..-D	515	515
R/L 510M1508-20	5	4,3	5	6,3	35	20	3	4,0	1,5	0,05	645.00..-D	615	615
R/L 510M2008-10	5	4,3	5	6,3	26	11	4	4,0	2,0	0,05	645.00..-D	520	520
R/L 510M2008-20	5	4,3	5	6,3	35	20	4	4,0	2,0	0,05	645.00..-D	620	620
R/L 010M1008-10	7	5,9	8	6,3	26	11	2	5,6	1,0	0,10	676.00..-D	800	800
R/L 010M1008-20	7	5,9	8	6,3	35	20	2	5,6	1,0	0,10	676.00..-D	810	810
R/L 010M1008-30	7	5,9	8	6,3	45	30	2	5,6	1,0	0,10	676.00..-D	820	820
R/L 010M1508-10	7	5,9	8	6,3	26	11	3	5,6	1,5	0,10	676.00..-D	802	802
R/L 010M1508-20	7	5,9	8	6,3	35	20	3	5,6	1,5	0,10	676.00..-D	812	812
R/L 010M1508-30	7	5,9	8	6,3	45	30	3	5,6	1,5	0,10	676.00..-D	822	822
R/L 010M2008-10	7	5,9	8	6,3	26	11	4	5,6	2,0	0,10	676.00..-D	804	804
R/L 010M2008-20	7	5,9	8	6,3	35	20	4	5,6	2,0	0,10	676.00..-D	814	814
R/L 010M2008-30	7	5,9	8	6,3	45	30	4	5,6	2,0	0,10	676.00..-D	824	824
R/L 010M2508-10	7	5,9	8	6,3	26	11	5	5,6	2,5	0,10	676.00..-D	806	806
R/L 010M2508-20	7	5,9	8	6,3	35	20	5	5,6	2,5	0,10	676.00..-D	816	816
R/L 010M2508-30	7	5,9	8	6,3	45	30	5	5,6	2,5	0,10	676.00..-D	826	826
R/L 010M3008-10	7	5,9	8	6,3	26	11	6	5,6	3,0	0,10	676.00..-D	808	808
R/L 010M3008-20	7	5,9	8	6,3	35	20	6	5,6	3,0	0,10	676.00..-D	818	818
R/L 010M3008-30	7	5,9	8	6,3	45	30	6	5,6	3,0	0,10	676.00..-D	828	828

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

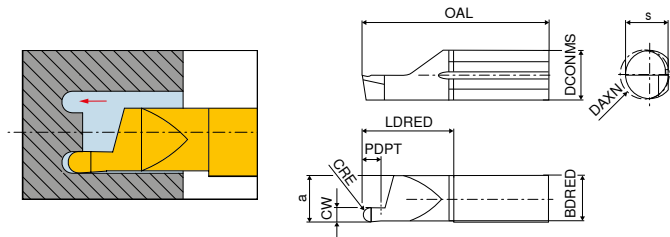
→ v_c Page 60

UltraMini – Inserts for axial grooving (Full radius)



Left-hand

Right-hand

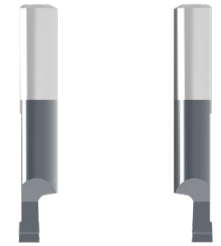
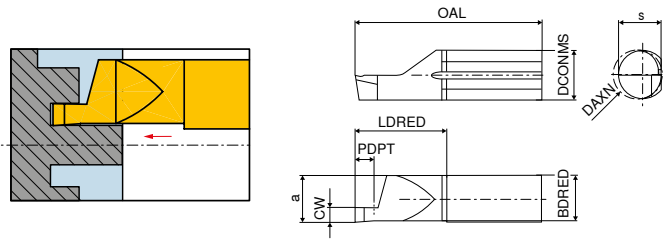


Illustrations show right-hand versions

Designation	DCONMS _{h6}	a	DAXN	s	OAL	LDRED	PDPT	BDRED	CW	CRE	Standard tool holder	Article no.	
												73 059 ...	73 058 ...
R/L 610.1005-10	6	5,2	6	5,3	26	11	2	4,9	1,0	0,50	676.00.-D	071	071
R/L 610.1005-20	6	5,2	6	5,3	35	20	2	4,9	1,0	0,50	676.00.-D	171	171
R/L 610.1608-10	6	5,2	6	5,3	26	11	3	4,9	1,6	0,80	676.00.-D	073	073
R/L 610.1608-20	6	5,2	6	5,3	35	20	3	4,9	1,6	0,80	676.00.-D	173	173
R/L 610.2010-10	6	5,2	6	5,3	26	11	4	4,9	2,0	1,00	676.00.-D	075	075
R/L 610.2010-20	6	5,2	6	5,3	35	20	4	4,9	2,0	1,00	676.00.-D	175	175
R/L 610.2512-10	6	5,2	6	5,3	26	11	5	4,9	2,5	1,25	676.00.-D	077	077
R/L 610.2512-20	6	5,2	6	5,3	35	20	5	4,9	2,5	1,25	676.00.-D	177	177
R/L 610.3015-10	6	5,2	6	5,3	26	11	6	4,9	3,0	1,50	676.00.-D	079	079
R/L 610.3015-20	6	5,2	6	5,3	35	20	6	4,9	3,0	1,50	676.00.-D	179	179
R/L 010.1005-10	7	5,9	8	6,3	26	11	2	5,6	1,0	0,50	676.00.-D	571	571
R/L 010.1005-20	7	5,9	8	6,3	35	20	2	5,6	1,0	0,50	676.00.-D	671	671
R/L 010.1608-10	7	5,9	8	6,3	26	11	3	5,6	1,6	0,80	676.00.-D	573	573
R/L 010.1608-20	7	5,9	8	6,3	35	20	3	5,6	1,6	0,80	676.00.-D	673	673
R/L 010.2010-10	7	5,9	8	6,3	26	11	4	5,6	2,0	1,00	676.00.-D	575	575
R/L 010.2010-20	7	5,9	8	6,3	35	20	4	5,6	2,0	1,00	676.00.-D	675	675
R/L 010.2512-10	7	5,9	8	6,3	26	11	5	5,6	2,5	1,25	676.00.-D	577	577
R/L 010.2512-20	7	5,9	8	6,3	35	20	5	5,6	2,5	1,25	676.00.-D	677	677
R/L 010.3015-10	7	5,9	8	6,3	26	11	6	5,6	3,0	1,50	676.00.-D	579	579
R/L 010.3015-20	7	5,9	8	6,3	35	20	6	5,6	3,0	1,50	676.00.-D	679	679
Steel												•	•
Stainless steel												•	•
Cast iron												•	•
Non ferrous metals												•	•
Heat resistant alloys												•	•
hardened materials												•	•

→ v_c Page 60

UltraMini – Inserts for axial grooving over a spigot



Left-hand

Right-hand

Illustrations show right-hand versions

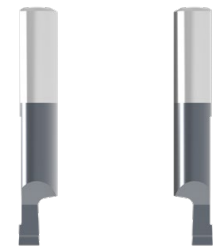
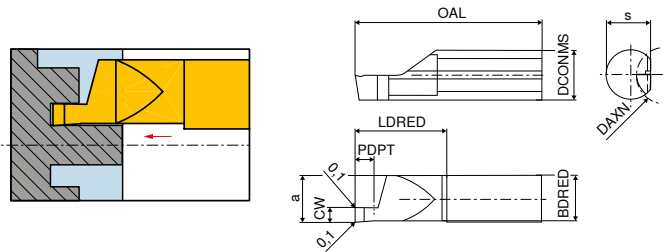
Designation	DCONMS _{h6}		DAXN	s	OAL	LDRED	PDPT	BDRED	CW	Standard tool holder	Article no.	
	mm	a									mm	mm
R/L 620.1006-20	6	5,2	6	5,3	35	20	2	4,9	1,0	676.00..-D	561	561
R/L 620.1506-20	6	5,2	6	5,3	35	20	3	4,9	1,5	676.00..-D	563	563
R/L 620.2006-20	6	5,2	6	5,3	35	20	4	4,9	2,0	676.00..-D	565	565
R/L 620.2506-20	6	5,2	6	5,3	35	20	5	4,9	2,5	676.00..-D	567	567
R/L 620.3006-20	6	5,2	6	5,3	35	20	6	4,9	3,0	676.00..-D	569	569

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials	•	•

→ v_c Page 60

UltraMini – Inserts for axial grooving over a spigot

▲ with corner radius



Left-hand

Right-hand

Illustrations show right-hand versions

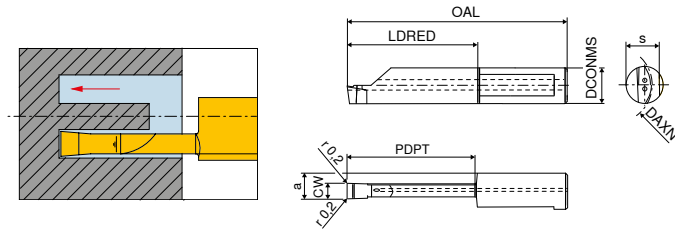
Designation	DCONMS _{h6}		DAXN	s	OAL	LDRED	PDPT	BDRED	CW	Standard tool holder	Article no.	
	mm	a									mm	mm
R/L 620M1006-20	6	5,2	6	5,3	35	20	2	4,9	1,0	676.00..-D	800	800
R/L 620M1506-20	6	5,2	6	5,3	35	20	3	4,9	1,5	676.00..-D	802	802
R/L 620M2006-20	6	5,2	6	5,3	35	20	4	4,9	2,0	676.00..-D	804	804
R/L 620M2506-20	6	5,2	6	5,3	35	20	5	4,9	2,5	676.00..-D	806	806
R/L 620M3006-20	6	5,2	6	5,3	35	20	6	4,9	3,0	676.00..-D	808	808

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials	•	•

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UltraMini – Inserts for axial grooving

- ▲ up to 100 bar
- ▲ dual cooling channel



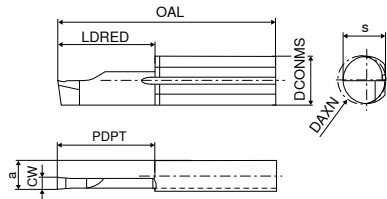
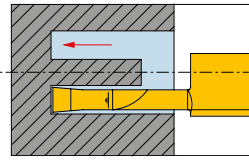
Illustrations show right-hand versions

Designation	DCONMS _{hg}		DAXN	s	OAL	LDRED	PDPT	CW	Standard tool holder	Left-hand		Right-hand	
	mm	a								mm	mm	mm	mm
R/L 012.0200-10	8	5,00	12	7,3	30	10	10	2,0	687.00..D	700			700
R/L 012.0200-15	8	5,00	12	7,3	35	15	15	2,0	687.00..D	702			702
R/L 012.0250-10	8	5,25	12	7,3	30	10	10	2,5	687.00..D	704			704
R/L 012.0250-20	8	5,25	12	7,3	40	20	20	2,5	687.00..D	706			706
R/L 016.0300-10	8	5,50	16	7,3	30	10	10	3,0	687.00..D	800			800
R/L 016.0300-20	8	5,50	16	7,3	40	20	20	3,0	687.00..D	802			802
R/L 020.0300-25	8	5,50	20	7,3	45	25	25	3,0	687.00..D	804			804
R/L 020.0300-30	8	5,50	20	7,3	50	30	30	3,0	687.00..D	806			806
R/L 020.0300-35	8	5,50	20	7,3	55	35	35	3,0	687.00..D	808			808
R/L 020.0300-40	8	5,50	20	7,3	60	40	40	3,0	687.00..D	810			810
R/L 016.0400-10	8	6,00	16	7,3	30	10	10	4,0	687.00..D	812			812
R/L 016.0400-20	8	6,00	16	7,3	40	20	20	4,0	687.00..D	814			814
R/L 020.0400-25	8	6,00	20	7,3	45	25	25	4,0	687.00..D	816			816
R/L 020.0400-30	8	6,00	20	7,3	50	30	30	4,0	687.00..D	818			818
R/L 020.0400-35	8	6,00	20	7,3	55	35	35	4,0	687.00..D	820			820
R/L 020.0400-40	8	6,00	20	7,3	60	40	40	4,0	687.00..D	822			822
R/L 020.0500.20	8	6,50	20	7,3	40	20	20	5,0	687.00..D	824			824
R/L 020.0500.25	8	6,50	20	7,3	45	25	25	5,0	687.00..D	826			826
R/L 020.0500.30	8	6,50	20	7,3	50	30	30	5,0	687.00..D	828			828
R/L 020.0500.35	8	6,50	20	7,3	55	35	35	5,0	687.00..D	830			830
R/L 020.0500.40	8	6,50	20	7,3	60	40	40	5,0	687.00..D	832			832

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials		

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UltraMini – Inserts for axial grooving



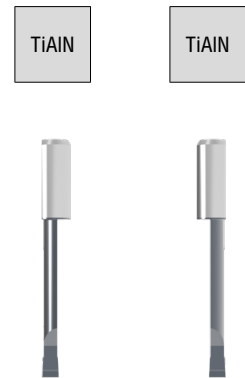
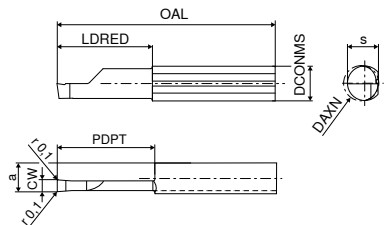
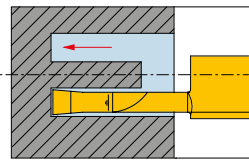
Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	Standard tool holder	Left-hand	Right-hand	Left-hand	Right-hand
										Article no. 73 055 ...	Article no. 73 054 ...	Article no. 73 057 ...	Article no. 73 056 ...
R/L 015.2515-20	7	5,9	15	6,3	35	20	20	2,5	676.00.-D	572	572	572	572
R/L 015.3015-20	7	5,9	15	6,3	35	20	20	3,0	676.00.-D	574	574	574	574
R/L 015.3015-30	7	5,9	15	6,3	45	30	30	3,0	676.00.-D	674	674	674	674
Steel										●	●	●	●
Stainless steel										●	●	●	●
Cast iron										○	○	○	○
Non ferrous metals										○	○	●	●
Heat resistant alloys										○	○	●	●
hardened materials													

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UltraMini – Inserts for axial grooving

▲ with corner radius



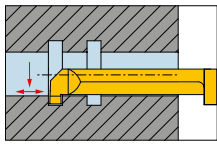
Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	Standard tool holder	Left-hand	Right-hand
										Article no. 73 257 ...	Article no. 73 256 ...
R/L 015M2515-20	7	5,9	8	6,3	35	20	20	2,5	676.00.-D	800	800
R/L 015M3015-20	7	5,9	8	6,3	35	20	20	3,0	676.00.-D	802	802
R/L 015M3015-30	7	5,9	8	6,3	45	30	30	3,0	676.00.-D	804	804
Steel										●	●
Stainless steel										●	●
Cast iron										●	●
Non ferrous metals										●	●
Heat resistant alloys										●	●
hardened materials											

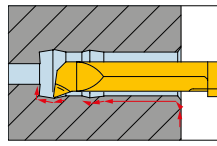
→ v_c Page 60

Set 1: Internal turning, grooving and chamfering, right hand

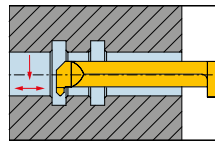
- ▲ extensive assortment of right-hand tools
- ▲ K10F - TiN



Grooving (E)



Profile turn (A)



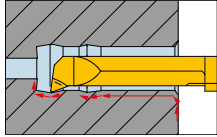
Chamfers (F)



Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Grooving depth mm	Groove width mm	Piece	fig.	Article no. 73 085 ...
Inserts	R 004.0100-16	73 002 541	4	16	0,8	1,0	1	E	999
Inserts	R 005.0150-20	73 002 552	5	20	1,0	1,5	1	E	
Inserts	R 005.0200-20	73 002 553	5	20	1,0	2,0	1	E	
Inserts	R 006.0150-22	73 002 562	6	22	1,8	1,5	1	E	
Inserts	R 006.0200-22	73 002 563	6	22	1,8	2,0	1	E	
Inserts	R 050.3-16	73 004 530	3	16			1	A	
Inserts	R 050.4-16	73 004 540	4	16			1	A	
Inserts	R 050.5-20	73 004 550	5	20			1	A	
Inserts	R 050.6-22	73 004 560	6	22			1	A	
Inserts	R 060.5-20	73 006 550	5	20			1	F	
Tool holder	645.0016-D	73 080 164					1		
Tool holder	676.0016-D	73 080 166					1		
Tightening Key	110.645	70 950 175					1		

Set 3: Internal Turning

- ▲ extensive assortment of right-hand tools
- ▲ K10F - TiN



Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Piece	Article no. 73 085 ...
Inserts	R 050.3-16	73 004 530	3	16	1	994
Inserts	R 050.4-16	73 004 540	4	16	1	
Inserts	R 050.5-20	73 004 550	5	20	1	
Inserts	R 050.6-22	73 004 560	6	22	1	
Tool holder	645.0016-D	73 080 164			1	
Tool holder	676.0016-D	73 080 166			1	
Tightening Key	110.645	70 950 175			1	

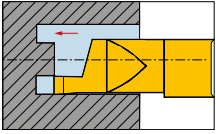
Set 4: Holder



Tool	Designation	Article No.	for cutting insert Ø mm	Piece	Article no. 73 085 ...
Tool holder	645.0016-D	73 080 164	3 / 4 / 5	1	990
Tool holder	676.0016-D	73 080 166	6 / 7	1	
Tightening Key	110.645	70 950 175		1	

Set 6: Axial Grooving

- ▲ extensive assortment of right-hand tools
- ▲ K10F - TiN



Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Grooving depth mm	Groove width mm	Piece
Inserts	R 010.1008-10	73 050 571	8	10	1,5	1,0	1
Inserts	R 010.1508-10	73 050 573	8	10	2,5	1,5	1
Inserts	R 010.2008-10	73 050 575	8	10	3,0	2,0	1
Inserts	R 010.2508-20	73 050 677	8	20	3,5	2,5	1
Inserts	R 010.3008-20	73 050 679	8	20	3,5	3,0	1
Tool holder	676.0016-D	73 080 166					1
Tightening Key	110.645	70 950 175					1

Article no.
73 085 ...

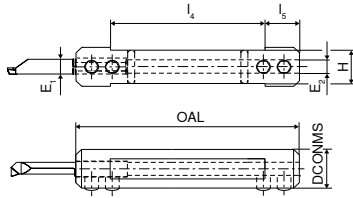
996

UltraMini – Standard tool holder for cutting inserts

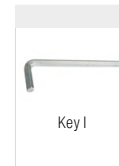
- ▲ double ended
- ▲ Machining diameter from Ø 0.2 mm

Scope of supply:

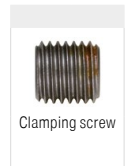
Tool holder with allen key



Designation	Ø E ₁ mm	Ø E ₂ mm	DCONMS mm	OAL mm	l ₄ mm	l ₅ mm	H mm	Article no. 73 080 ...
645.0012-D	4	5	12,00	75	55	10	10,3	163
645.0016-D	4	5	16,00	75	55	10	14,0	164
645.001905-D	4	5	19,05	90	70	10	17,2	170
645.0020-D	4	5	20,00	90	70	10	18,0	165
645.0022-D	4	5	22,00	90	70	10	20,0	171
645.00254-D	4	5	25,40	95	75	10	23,4	172
676.0016-D	6	7	16,00	75	55	10	14,0	166
676.001905-D	6	7	19,05	90	70	10	17,2	173
676.0020-D	6	7	20,00	90	70	10	18,0	167
676.0022-D	6	7	22,00	90	70	10	20,0	174
676.00254-D	6	7	25,40	95	75	10	23,4	175
687.0016-D	7	8	16,00	75	55	10	14,0	168
687.0020-D	7	8	20,00	90	70	10	18,0	169



Key I



Clamping screw

Spare parts

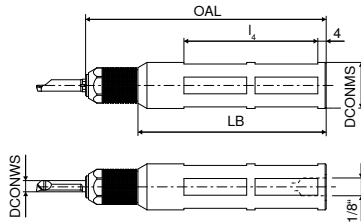
for Article no.

	Article no. 70 950 ...	Article no. 73 082 ...
73 080 163	SW2,5 175	M5x4 013
73 080 164	SW2,5 175	M5x6 001
73 080 170	SW2,5 175	M5x6 001
73 080 165	SW2,5 175	M5x8 008
73 080 171	SW2,5 175	M5x8 008
73 080 172	SW2,5 175	M5x8 008
73 080 166	SW2,5 175	M5x6 001
73 080 173	SW2,5 175	M5x6 001
73 080 167	SW2,5 175	M5x8 008
73 080 174	SW2,5 175	M5x8 008
73 080 175	SW2,5 175	M5x8 008
73 080 168	SW2,5 175	M6x6 014
73 080 169	SW2,5 175	M6x6 014

UltraMini – Quick change tool holder for cutting inserts

Scope of supply:

Tool holder, lock nut and clamping wedge

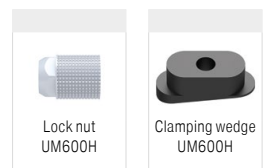


Designation	DCONWS	DCONMS _{g6}	OAL	LB	l _s	Article no. 73 089 ...
	mm	mm	mm	mm	mm	
UM600H.0012.4	4	12,00	115	90	64	124
UM600H.0016.4	4	16,00	115	90	64	164
UM600H.001905.4	4	19,05	115	90	64	194
UM600H.0020.4	4	20,00	115	90	64	204
UM600H.0022.4	4	22,00	115	90	64	224
UM600H.0025.4	4	25,00	115	90	64	254
UM600H.00254.4	4	25,40	115	90	64	264
UM600H.0028.4	4	28,00	115	90	64	284
UM600H.0012.5	5	12,00	115	90	64	125
UM600H.0016.5	5	16,00	115	90	64	165
UM600H.001905.5	5	19,05	115	90	64	195
UM600H.0020.5	5	20,00	115	90	64	205
UM600H.0022.5	5	22,00	115	90	64	225
UM600H.0025.5	5	25,00	115	90	64	255
UM600H.00254.5	5	25,40	115	90	64	265
UM600H.0028.5	5	28,00	115	90	64	285
UM600H.0012.6	6	12,00	115	90	64	126
UM600H.0016.6	6	16,00	115	90	64	166
UM600H.001905.6	6	19,05	115	90	64	196
UM600H.0020.6	6	20,00	115	90	64	206
UM600H.0022.6	6	22,00	115	90	64	226
UM600H.0025.6	6	25,00	115	90	64	256
UM600H.00254.6	6	25,40	115	90	64	266
UM600H.0028.6	6	28,00	115	90	64	286
UM600H.0012.7	7	12,00	115	90	64	127
UM600H.0016.7	7	16,00	115	90	64	167
UM600H.001905.7	7	19,05	115	90	64	197
UM600H.0020.7	7	20,00	115	90	64	207
UM600H.0022.7	7	22,00	115	90	64	227
UM600H.0025.7	7	25,00	115	90	64	257
UM600H.00254.7	7	25,40	115	90	64	267
UM600H.0028.7	7	28,00	115	90	64	287

i Avoid pulling cuts. Ensure a suitable clamping force is used when using thro' coolant supply. Can be tightened using a key.

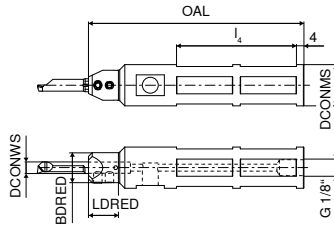
Spare parts
DCONWS

		Article no. 73 950 ...	Article no. 73 950 ...
4	M4	104	111
5	M5	105	111
6	M6	106	111
7	M7	107	111



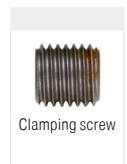
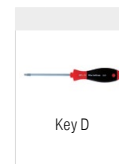
UltraMini – Toolholder for inserts

▲ Tool holder suitable for high coolant pressures



Designation	DCONWS	BDRED	DCONMS _{g6}	OAL	LDRED	l ₄	Article no. 73 088 ...
	mm	mm	mm	mm	mm		
UMST.0016.4	4	16	16,00	115	24	42	164
UMST.001905.4	4	16	19,05	115	24	42	194
UMST.0020.4	4	16	20,00	115	24	42	204
UMST.0022.4	4	16	22,00	115	24	42	224
UMST.00254.4	4	16	25,40	115	24	42	264
UMST.0028.4	4	16	28,00	115	24	42	284
UMST.0016.5	5	16	16,00	115	24	42	165
UMST.001905.5	5	16	19,05	115	24	42	195
UMST.0020.5	5	16	20,00	115	24	42	205
UMST.0022.5	5	16	22,00	115	24	42	225
UMST.00254.5	5	16	25,40	115	24	42	265
UMST.0028.5	5	16	28,00	115	24	42	285
UMST.0016.6	6	16	16,00	115	24	42	166
UMST.001905.6	6	16	19,05	115	24	42	196
UMST.0020.6	6	16	20,00	115	24	42	206
UMST.0022.6	6	16	22,00	115	24	42	226
UMST.00254.6	6	16	25,40	115	24	42	266
UMST.0028.6	6	16	28,00	115	24	42	286
UMST.0016.7	7	16	16,00	115	24	42	167
UMST.001905.7	7	16	19,05	115	24	42	197
UMST.0020.7	7	16	20,00	115	24	42	207
UMST.0022.7	7	16	22,00	115	24	42	227
UMST.00254.7	7	16	25,40	115	24	42	267
UMST.0028.7	7	16	28,00	115	24	42	287
UMST.0016.8	8	16	16,00	115	24	42	168
UMST.001905.8	8	16	19,05	115	24	42	198
UMST.0020.8	8	16	20,00	115	24	42	208
UMST.0022.8	8	16	22,00	115	24	42	228
UMST.00254.8	8	16	25,40	115	24	42	268
UMST.0028.8	8	16	28,00	115	24	42	288

i up to 150 bar



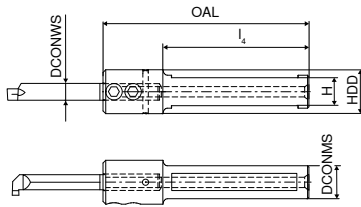
Spare parts DCONWS	Article no. 80 950 ...	Article no. 73 950 ...
4	T10 104	M5x0,5x6T10 050
5	T10 104	M5x0,5x6T10 050
6	T10 104	M5x0,5x6T10 050
7	T10 104	M5x0,5x6T10 050
8	T10 104	M5x0,5x6T10 050

UltraMini – Toolholder for inserts

▲ single ended

Scope of supply:

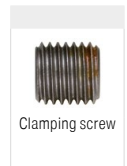
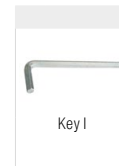
Tool holder with allen key



Designation	DCONWS	HDD	DCONMS	OAL	l ₄	H	Article no. 73 081 ...
	mm	mm	mm	mm	mm	mm	
640.0012-D	4	16	12	75	53	10,2	264
650.0012-D	5	16	12	75	53	10,2	265
660.0012-D	6	16	12	75	53	10,2	266
670.0012-D	7	16	12	75	53	10,2	267
680.0012-D	8	16	12	75	53	10,2	268

Spare parts
DCONWS

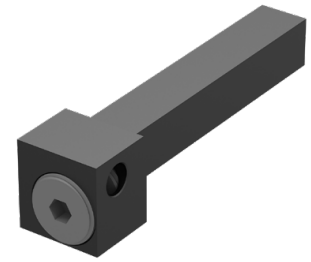
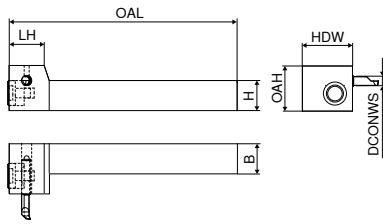
DCONWS		Article no. 70 950 ...		Article no. 73 082 ...
4	SW2,5	175	M5x0,5x6	010
5	SW2,5	175	M5x0,5x6	010
6	SW2,5	175	M5x0,5x6	010
7	SW2,5	175	M5x0,5x6	010
8	SW2,5	175	M5x0,5x6	010



UltraMini – Toolholder for inserts

Scope of supply:

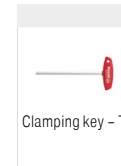
Tool holder with allen key



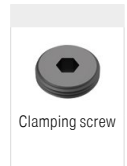
Illustrations show right-hand versions

Designation	DCONWS	OAL	LH	B	HDW	H	OAH	Left-hand		Right-hand	
								Article no.	Article no.	Article no.	Article no.
R/L .UHCM.1212.4	4	90	17	12	20	12	18	73 083 ...	124	73 084 ...	124
R/L .UHCM.1212.5	5	90	17	12	20	12	18	125	125	125	125
R/L .UHCM.1212.6	6	90	17	12	20	12	21	126	126	126	126
R/L .UHCM.1212.7	7	90	17	12	20	12	21	127	127	127	127

Spare parts
DCONWS



Clamping key - T



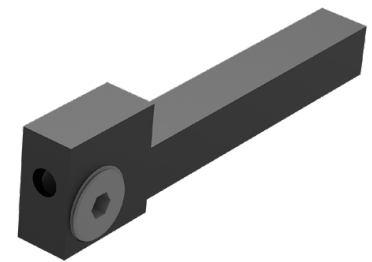
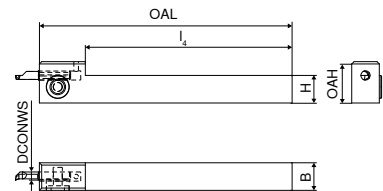
Clamping screw

DCONWS	Article no.	Article no.	Article no.	Article no.
4	80 397 ...	050	UM 12	011
5	80 397 ...	050	UM 12	011
6	80 397 ...	050	UM 16	012
7	80 397 ...	050	UM 16	012

UltraMini – Toolholder for inserts

Scope of supply:

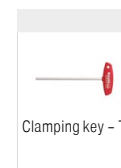
Tool holder with allen key



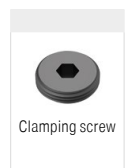
12

Designation	DCONWS	OAL	l ₄	B	H	OAH	Article no.	
							Article no.	Article no.
UM.1010.4	4	100	75	10	10	20	73 086 ...	104
UM.1010.5	5	100	75	10	10	20	105	105
UM.1212.4	4	100	75	12	12	22	124	124
UM.1212.5	5	100	75	12	12	22	125	125
UM.1212.6	6	100	75	12	12	22	126	126

Spare parts
DCONWS



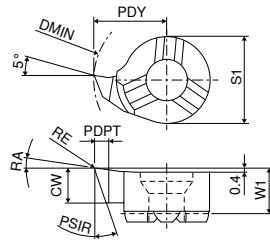
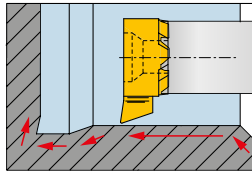
Clamping key - T



Clamping screw

DCONWS	Article no.	Article no.	Article no.	Article no.
4	80 397 ...	050	UM 12	011
5	80 397 ...	050	UM 12	011
6	80 397 ...	050	UM 16	012

MiniCut – Insert for turning and profiling



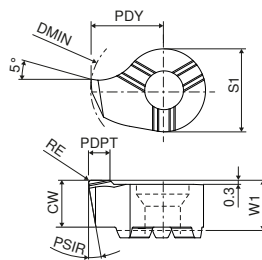
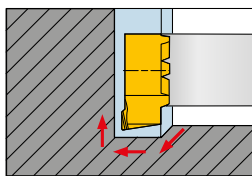
Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left-hand	Right-hand	
											Article no. 73 324 ...	Article no. 73 322 ...	
08	8,00. R/L .3.30.18°	7,8	3,3	3,5	4,65	6,0	0,20	0,6	18	8	033	033	
	8,00. R/L .3.50.18°	7,8	3,5	3,5	4,65	6,0	0,05	0,6	18	8	035	035	
	8,00. R/L .3.50.20°	7,8	3,5	3,5	4,65	6,0	0,20	0,6	20	20	135	135	
09	9,00. R/L .3.60.18°	9,0	3,6	3,6	5,50	6,2	0,20	0,8	18	8	136	136	
	9,00. R/L .3.60.20°	9,0	3,6	3,6	5,50	6,2	0,20	0,8	20	20	236	236	
11	9,80. R/L .3.90.18°	9,8	3,9	4,2	5,50	8,0	0,20	1,0	18	8	139	139	
	11,00. R/L .3.90.18°	11,0	3,9	4,2	6,70	8,0	0,20	1,0	18	8	339	339	
	11,00. R/L .4.20.20°	11,0	4,2	4,2	6,70	8,0	0,20	1,0	20	20	342	342	
14	14,00. R/L .5.00.18°	13,8	5,0	5,1	8,70	9,0	0,20	1,5	18	8	550	550	
	14,00. R/L .5.30.20°	14,0	5,3	5,3	8,70	9,0	0,20	1,5	20	20	553	553	
16	15,50. R/L .5.00.18°	15,5	5,0	5,4	9,70	11,0	0,20	1,5	18	8	750	750	
Steel												●	●
Stainless steel												●	●
Cast iron												●	●
Non ferrous metals												●	●
Heat resistant alloys												●	●
hardened materials												●	●

→ v_c Page 60

MiniCut – Insert for copy turning

▲ with chip breaker



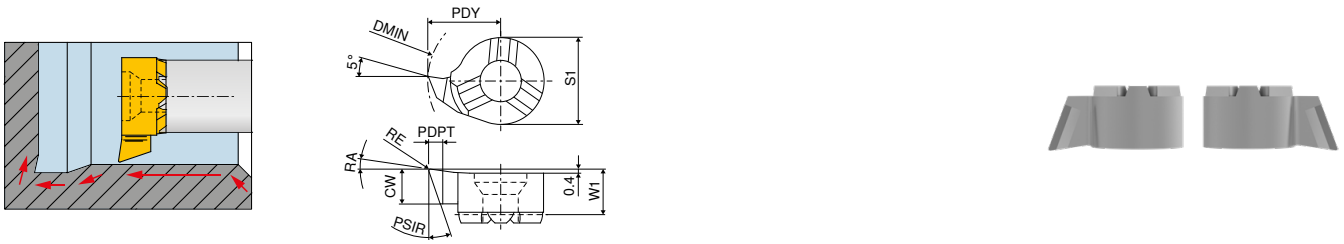
Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	Left-hand	Right-hand		
										Article no. 73 388 ...	Article no. 73 386 ...		
08	8,00. R/L .3.40.10°	8	3,4	3,5	4,65	6,0	0,2	0,5	10	13400	13400		
09	9,00. R/L .3.50.10°	9	3,5	3,6	5,50	6,2	0,2	0,5	10	136	136		
11	11,00. R .4.10.10°	11	4,1	4,2	6,70	8,0	0,2	0,5	10	14100	14100		
Steel												●	●
Stainless steel												●	●
Cast iron												●	●
Non ferrous metals												●	●
Heat resistant alloys												●	●
hardened materials												●	●

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MiniCut – CBN insert for profiling – hard turning

▲ 56 to 65 HRC



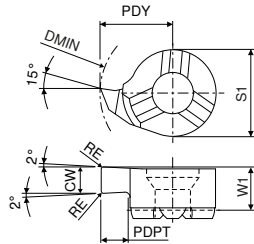
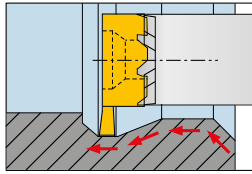
Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left-hand CBN	Right-hand CBN
											Article no. 73 368 ...	Article no. 73 366 ...
08	8,00. R/L .3,30.18°	7,8	3,3	3,5	4,65	6	0,2	0,39	18	8	033	033
11	11,00. R/L .3,90.18°	11,0	3,9	4,2	6,70	8	0,2	0,55	18	8	139	139
14	14,00. R/L .5,00.18°	13,8	5,0	5,3	8,70	9	0,2	0,69	18	8	550	550
16	16,00. R/L .5,00.18°	15,5	5,0	5,4	9,70	11	0,2	0,77	18	8	750	750

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials	●	●

→ v_c Page 60

MiniCut – Internal turning insert

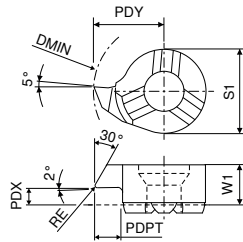
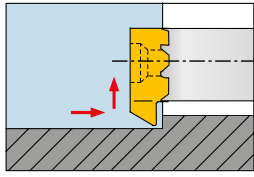


Illustrations show right-hand versions

Size	Designation	DMIN mm	CW _{-0.05} mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	Left-hand	Right-hand
										Article no. 73 316 ...	Article no. 73 314 ...
08	8,00. R/L .1,50.1,0	8	1,5	1,0	3,3	4,8	6,0	0,2	0,2	015	015
	8,00. R/L .2,00.1,0	8	2,0	1,0	3,3	4,8	6,0	0,2	0,2	020	020
09	9,00. R/L .1,50.2,0	9	1,5	2,0	3,6	5,5	6,2	0,2	0,2	115	115
	9,00. R/L .1,50.3,0	10	1,5	3,0	3,6	6,5	6,2	0,2	0,2	121	121
	9,00. R/L .2,00.2,0	9	2,0	2,0	3,6	5,5	6,2	0,2	0,2	120	120
	9,00. R/L .2,00.3,0	10	2,0	3,0	3,6	6,5	6,2	0,2	0,2	122	122
11	11,00. R/L .1,50.2,3	11	1,5	2,3	4,2	6,7	8,0	0,2	0,2	315	315
	11,00. R/L .2,00.2,3	11	2,0	2,3	4,2	6,7	8,0	0,2	0,2	320	320
14	14,00. R/L .1,50.4,0	14	1,5	4,0	5,3	9,0	9,0	0,2	0,2	515	515
	14,00. R/L .1,50.5,5	16	1,5	5,5	5,2	10,5	9,0	0,2	0,2	516	516
	14,00. R/L .1,50.6,5	17	1,5	6,5	5,2	11,5	9,0	0,2	0,2	517	517
	14,00. R/L .2,00.4,0	14	2,0	4,0	5,3	9,0	9,0	0,2	0,2	520	520
	14,00. R/L .2,00.5,5	16	2,0	5,5	5,2	10,5	9,0	0,2	0,2	521	521
	14,00. R/L .2,00.6,5	17	2,0	6,5	5,2	11,5	9,0	0,2	0,2	522	522
	14,00. R/L .2,50.5,5	16	2,5	5,5	5,2	10,5	9,0	0,2	0,2	525	525
	14,00. R/L .2,50.6,5	17	2,5	6,5	5,2	11,5	9,0	0,2	0,2	526	526
	14,00. R/L .3,00.5,5	16	3,0	5,5	5,2	10,5	9,0	0,2	0,2	530	530
	14,00. R/L .3,00.6,5	17	3,0	6,5	5,2	11,5	9,0	0,2	0,2	531	531
16	16,00. R/L .2,00.4,3	16	2,0	4,3	5,4	10,2	11,0	0,2	0,2	720	720
Steel										●	●
Stainless steel										●	●
Cast iron										●	●
Non ferrous metals										●	●
Heat resistant alloys										●	●
hardened materials										●	●

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MiniCut – Back boring insert



CWX500

CWX500

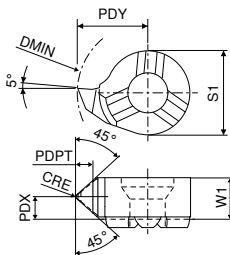
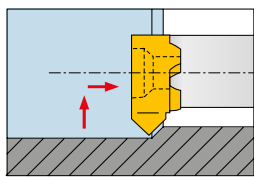


Illustrations show right-hand versions

Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	CDX mm	Left-hand	Right-hand
										Article no. 73 332 ...	Article no. 73 330 ...
08	8,00. R/L .30°1,3	7,8	1,3	3,50	1,0	4,65	6,0	0,2	0,6	013	013
09	9,00. R/L .30°1,7	9,0	1,7	3,55	1,2	5,50	6,2	0,2	0,8	117	117
	9,00. R/L .30°2,3	10,0	2,3	3,55	1,2	6,50	6,2	0,2	0,8	123	123
11	11,00. R/L .30°2,3	11,0	2,3	4,30	1,6	6,70	8,0	0,2	1,0	323	323
14	14,00. R/L .30°3,5	13,8	3,5	5,40	2,4	8,70	9,0	0,2	1,5	535	535
										●	●
Steel										●	●
Stainless steel										●	●
Cast iron										●	●
Non ferrous metals										●	●
Heat resistant alloys										●	●
hardened materials										●	●

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MiniCut – Internal turning and chamfering insert



CWX500

CWX500



12

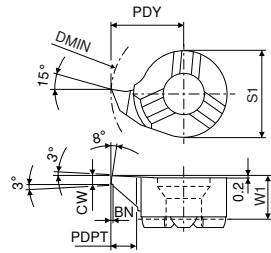
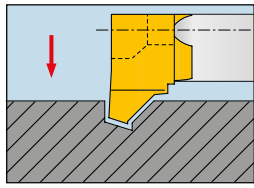
Illustrations show right-hand versions

Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	CRE mm	CDX mm	Left-hand	Right-hand
										Article no. 73 336 ...	Article no. 73 334 ...
08	8,00. R/L .45°1,4	8	1,4	3,50	1,8	4,8	6,0	0,2	0,6	010	010
09	9,00. R/L .45°1,3	9	1,3	3,55	1,8	5,5	6,2	0,2	0,8	110	110
	11,00. R/L .45°1,5	11	1,5	4,30	2,2	6,7	8,0	0,2	1,0	310	310
14	14,00. R/L .45°1,5	14	1,5	5,40	2,8	9,0	9,0	0,2	1,2	510	510
										●	●
Steel										●	●
Stainless steel										●	●
Cast iron										●	●
Non ferrous metals										●	●
Heat resistant alloys										●	●
hardened materials										●	●

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MiniCut – Insert for pregrooving and chamfering

CWX500 CWX500

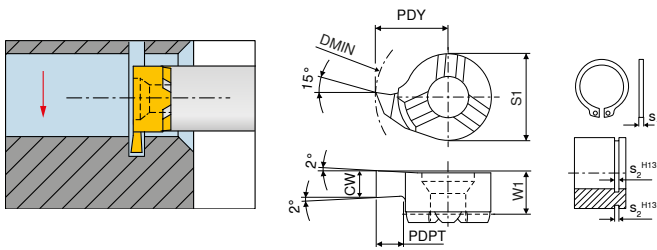


Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	BN mm	Left-hand	Right-hand	
									Article no. 73 340 ...	Article no. 73 338 ...	
08	8,00. R/L .1,00.45°	8	1	1,0	3,3	4,8	6,0	0,2	100	100	
09	9,00. R/L .1,00.45°	9	1	1,5	3,6	5,5	6,2	0,2	215	215	
11	11,00. R/L .1,00.45°	11	1	1,5	4,2	6,7	8,0	0,2	315	315	
14	14,00. R/L .1,00.45°	14	1	1,5	5,3	9,0	9,0	0,2	515	515	
16	16,00. R/L .1,00.45°	16	1	1,5	5,4	10,2	11,0	0,2	715	715	
									Steel	•	•
									Stainless steel	•	•
									Cast iron	•	•
									Non ferrous metals	•	•
									Heat resistant alloys	•	•
									hardened materials		

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MiniCut – Grooving insert



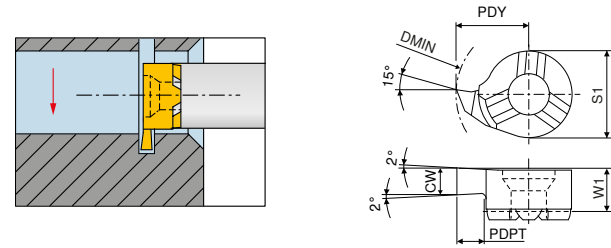
Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	S1 mm	S2 H13 mm	PDY mm	S1 mm	Left-hand	Right-hand
										Article no. 73 312 ...	Article no. 73 310 ...
08	8,00. R/L .073.1,0	8	0,73	1,0	3,3	0,6	0,7	4,8	6,0	073	073
	8,00. R/L .083.1,0	8	0,83	1,0	3,3	0,7	0,8	4,8	6,0	083	083
	8,00. R/L .093.1,0	8	0,93	1,0	3,3	0,8	0,9	4,8	6,0	093	093
	8,00. R/L .100.1,0	8	1,00	1,0	3,3			4,8	6,0	110	110
	8,00. R/L .120.1,0	8	1,20	1,0	3,3	1,0	1,1	4,8	6,0	112	112
	8,00. R/L .140.1,0	8	1,40	1,0	3,3	1,2	1,3	4,8	6,0	114	114
	8,00. R/L .150.1,0	8	1,50	1,0	3,3			4,8	6,0	115	115
	8,00. R/L .170.1,0	8	1,70	1,0	3,3	1,5	1,6	4,8	6,0	117	117
	8,00. R/L .200.1,0	8	2,00	1,0	3,3			4,8	6,0	120	120
09	9,00. R/L .073.1,2	9	0,73	1,2	3,6	0,6	0,7	5,5	6,2	173	173
	9,00. R/L .083.1,3	9	0,83	1,3	3,6	0,7	0,8	5,5	6,2	183	183
	9,00. R/L .093.1,5	9	0,93	1,5	3,6	0,8	0,9	5,5	6,2	193	193
	9,00. R/L .100.1,8	9	1,00	1,8	3,6			5,5	6,2	210	210
	9,00. R/L .120.1,8	9	1,20	1,8	3,6	1,0	1,1	5,5	6,2	212	212
	9,00. R/L .140.1,8	9	1,40	1,8	3,6	1,2	1,3	5,5	6,2	214	214
	9,00. R/L .150.1,8	9	1,50	1,8	3,6			5,5	6,2	215	215
	9,00. R/L .170.1,8	9	1,70	1,8	3,6	1,5	1,6	5,5	6,2	217	217
	9,00. R/L .200.1,8	9	2,00	1,8	3,6			5,5	6,2	220	220
	9,00. R/L .250.1,8	9	2,50	1,8	3,6			5,5	6,2	225	225
9,00. R/L .300.1,8	9	3,00	1,8	3,6			5,5	6,2	230	230	
11	11,00. R/L .073.1,2	11	0,73	1,2	4,2	0,6	0,7	6,7	8,0	373	373
	11,00. R/L .083.1,3	11	0,83	1,3	4,2	0,7	0,8	6,7	8,0	383	383
	11,00. R/L .093.1,5	11	0,93	1,5	4,2	0,8	0,9	6,7	8,0	393	393
	11,00. R/L .100.2,3	11	1,00	2,3	4,2			6,7	8,0	310	310
	11,00. R/L .120.2,3	11	1,20	2,3	4,2	1,0	1,1	6,7	8,0	312	312
	11,00. R/L .140.2,3	11	1,40	2,3	4,2	1,2	1,3	6,7	8,0	314	314
	11,00. R/L .150.2,3	11	1,50	2,3	4,2			6,7	8,0	315	315
	11,00. R/L .170.2,3	11	1,70	2,3	4,2	1,5	1,6	6,7	8,0	317	317
	11,00. R/L .200.2,3	11	2,00	2,3	4,2			6,7	8,0	320	320
	11,00. R/L .250.2,3	11	2,50	2,3	4,2			6,7	8,0	325	325
	11,00. R/L .300.2,3	11	3,00	2,3	4,2			6,7	8,0	330	330
14	14,00. R/L .073.1,2	14	0,73	1,2	5,3	0,6	0,7	9,0	9,0	573	573
	14,00. R/L .083.1,3	14	0,83	1,3	5,3	0,7	0,8	9,0	9,0	583	583
	14,00. R/L .093.1,5	14	0,93	1,5	5,3	0,8	0,9	9,0	9,0	593	593
	14,00. R/L .120.4,0	14	1,20	4,0	5,3	1,0	1,1	9,0	9,0	512	512
	14,00. R/L .140.4,0	14	1,40	4,0	5,3	1,2	1,3	9,0	9,0	514	514
	14,00. R/L .150.4,0	14	1,50	4,0	5,3			9,0	9,0	515	515
	14,00. R/L .170.4,0	14	1,70	4,0	5,3	1,5	1,6	9,0	9,0	517	517
	14,00. R/L .200.4,0	14	2,00	4,0	5,3			9,0	9,0	520	520
	14,00. R/L .250.4,0	14	2,50	4,0	5,3			9,0	9,0	525	525
	14,00. R/L .300.4,0	14	3,00	4,0	5,3			9,0	9,0	530	530
16	16,00. R/L .073.1,2	16	0,73	1,2	5,4	0,6	0,7	10,2	11,0	773	773
	16,00. R/L .083.1,3	16	0,83	1,3	5,4	0,7	0,8	10,2	11,0	783	783
	16,00. R/L .093.1,5	16	0,93	1,5	5,4	0,8	0,9	10,2	11,0	793	793
	16,00. R/L .120.4,3	16	1,20	4,3	5,4	1,0	1,1	10,2	11,0	712	712
	16,00. R/L .140.4,3	16	1,40	4,3	5,4	1,2	1,3	10,2	11,0	714	714
	16,00. R/L .150.4,3	16	1,50	4,3	5,4			10,2	11,0	715	715
	16,00. R/L .170.4,3	16	1,70	4,3	5,4	1,5	1,6	10,2	11,0	717	717
	16,00. R/L .200.4,3	16	2,00	4,3	5,4			10,2	11,0	720	720
	16,00. R/L .250.4,3	16	2,50	4,3	5,4			10,2	11,0	725	725
	16,00. R/L .300.4,3	16	3,00	4,3	5,4			10,2	11,0	730	730
	16,00. R/L .350.4,3	16	3,50	4,3	5,4			10,2	11,0	735	735
	16,00. R/L .400.4,3	16	4,00	4,3	5,4			10,2	11,0	740	740

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

MiniCut – Grooving insert

▲ large groove depth (T_{max} 5.5 mm)



Illustrations show right-hand versions

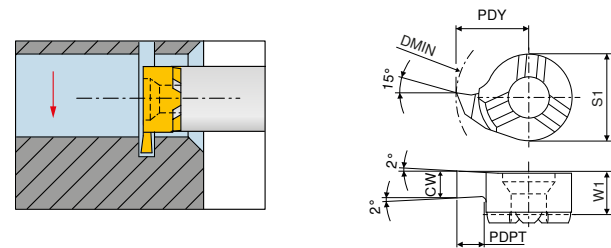
Size	Designation	DMIN	CW ^{-0.03}	PDPT	W1	PDY	S1
		mm	mm	mm	mm	mm	mm
14	14,00. R/L .1,50.5,5	16	1,5	5,5	5,2	10,5	9
	14,00. R/L .2,00.5,5	16	2,0	5,5	5,2	10,5	9
	14,00. R/L .2,50.5,5	16	2,5	5,5	5,2	10,5	9
	14,00. R/L .3,00.5,5	16	3,0	5,5	5,2	10,5	9

	Left-hand Article no. 73 372 ...	Right-hand Article no. 73 370 ...
Steel	715	715
Stainless steel	720	720
Cast iron	725	725
Non ferrous metals	730	730
Heat resistant alloys		
hardened materials		

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MiniCut – Grooving insert

▲ large groove depth (T_{max} 6.5 mm)



Illustrations show right-hand versions

Size	Designation	DMIN	CW ^{-0.03}	PDPT	W1	PDY	S1
		mm	mm	mm	mm	mm	mm
14	14,00. R/L .1,50.6,5	17	1,5	6,5	5,2	11,5	9
	14,00. R/L .2,00.6,5	17	2,0	6,5	5,2	11,5	9
	14,00. R/L .2,50.6,5	17	2,5	6,5	5,2	11,5	9
	14,00. R/L .3,00.6,5	17	3,0	6,5	5,2	11,5	9

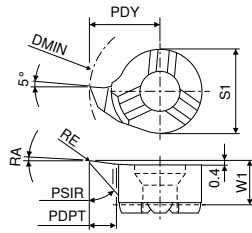
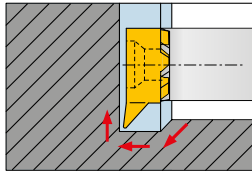
	Left-hand Article no. 73 384 ...	Right-hand Article no. 73 382 ...
Steel	515	515
Stainless steel	520	520
Cast iron	525	525
Non ferrous metals	530	530
Heat resistant alloys		
hardened materials		

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MiniCut – Internal undercut insert

CWX500

CWX500

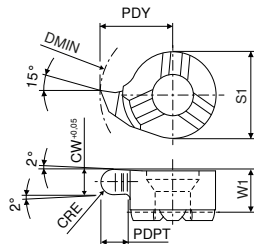
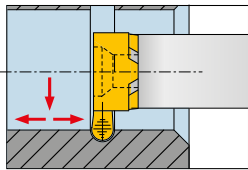


Illustrations show right-hand versions

Size	Designation	DMIN mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	PSIR °	RA °	Left-hand	Right-hand
											Article no. 73 328 ...	Article no. 73 326 ...
08	8,00. R/L .30°1,0	7,8	1,0	3,5	4,65	6,0	0,2	0,4	30	3	010	010
	8,00. R/L .47°1,2	7,8	1,2	3,5	4,65	6,0	0,2	0,4	47	3	012	012
09	9,00. R/L .47°1,5	9,0	1,5	3,6	5,50	6,2	0,2	0,5	47	3	115	115
11	11,00. R/L .30°2,3	11,0	2,3	4,2	6,70	8,0	0,2	0,6	30	3	423	423
	11,00. R/L .47°2,3	11,0	2,3	4,2	6,70	8,0	0,2	0,6	47	3	323	323
14	13,70. R/L .47°3,0	13,7	3,0	5,3	8,70	9,0	0,2	0,8	47	3	530	530
	13,70. R/L .30°4,0	13,7	4,0	5,3	8,70	9,0	0,2	0,8	30	3	540	540
16	15,80. R/L .30°4,3	15,8	4,3	5,4	10,20	11,0	0,2	1,0	30	3	744	744
Steel											●	●
Stainless steel											●	●
Cast iron											●	●
Non ferrous metals											●	●
Heat resistant alloys											●	●
hardened materials												

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MiniCut – Full radius grooving and turning insert

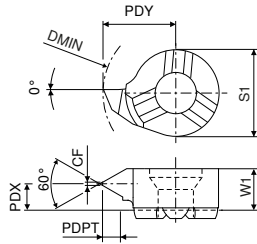
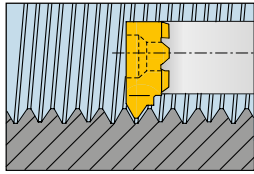


Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	CRE mm	Left-hand	Right-hand
									Article no. 73 320 ...	Article no. 73 318 ...
08	8,00. R/L .0,80.1,0	8	0,8	1,0	3,3	4,8	6,0	0,4	008	008
	8,00. R/L .1,20.1,0	8	1,2	1,0	3,3	4,8	6,0	0,6	012	012
	8,00. R/L .1,80.1,0	8	1,8	1,0	3,3	4,8	6,0	0,9	018	018
	8,00. R/L .2,00.1,0	8	2,0	1,0	3,3	4,8	6,0	1,0	020	020
09	9,00. R/L .0,80.1,6	9	0,8	1,6	3,6	5,5	6,2	0,4	108	108
	9,00. R/L .1,20.1,6	9	1,2	1,6	3,6	5,5	6,2	0,6	112	112
	9,00. R/L .1,80.1,6	9	1,8	1,6	3,6	5,5	6,2	0,9	118	118
	9,00. R/L .2,00.1,6	9	2,0	1,6	3,6	5,5	6,2	1,0	120	120
11	11,00. R/L .0,80.2,3	11	0,8	2,3	4,2	6,7	8,0	0,4	308	308
	11,00. R/L .1,20.2,3	11	1,2	2,3	4,2	6,7	8,0	0,6	312	312
	11,00. R/L .1,60.2,3	11	1,6	2,3	4,2	6,7	8,0	0,8	316	316
	11,00. R/L .1,80.2,3	11	1,8	2,3	4,2	6,7	8,0	0,9	318	318
	11,00. R/L .2,00.2,3	11	2,0	2,3	4,2	6,7	8,0	1,0	320	320
	11,00. R/L .2,40.2,3	11	2,4	2,3	4,2	6,7	8,0	1,2	324	324
	11,00. R/L .3,00.2,3	11	3,0	2,3	4,2	6,7	8,0	1,5	330	330
14	14,00. R/L .0,80.4,0	14	0,8	4,0	5,3	9,0	9,0	0,4	508	508
	14,00. R/L .1,20.4,0	14	1,2	4,0	5,3	9,0	9,0	0,6	512	512
	14,00. R/L .1,80.4,0	14	1,8	4,0	5,3	9,0	9,0	0,9	518	518
	14,00. R/L .2,00.4,0	14	2,0	4,0	5,3	9,0	9,0	1,0	520	520
	14,00. R/L .2,20.4,0	14	2,2	4,0	5,3	9,0	9,0	1,1	522	522
	14,00. R/L .3,00.4,0	14	3,0	4,0	5,3	9,0	9,0	1,5	530	530
16	16,00. R/L .1,60.4,3	16	1,6	4,3	5,4	10,2	11,0	0,8	716	716
	16,00. R/L .1,80.4,3	16	1,8	4,3	5,4	10,2	11,0	0,9	718	718
	16,00. R/L .2,00.4,3	16	2,0	4,3	5,4	10,2	11,0	1,0	720	720
	16,00. R/L .2,20.4,3	16	2,2	4,3	5,4	10,2	11,0	1,1	722	722
	16,00. R/L .2,40.4,3	16	2,4	4,3	5,4	10,2	11,0	1,2	724	724
	16,00. R/L .3,00.4,3	16	3,0	4,3	5,4	10,2	11,0	1,5	730	730
	16,00. R/L .3,20.4,3	16	3,2	4,3	5,4	10,2	11,0	1,6	732	732
	16,00. R/L .4,00.4,3	16	4,0	4,3	5,4	10,2	11,0	2,0	740	740
Steel									●	●
Stainless steel									●	●
Cast iron									●	●
Non ferrous metals									●	●
Heat resistant alloys									●	●
hardened materials										

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MiniCut – Threading insert (Partial profile)



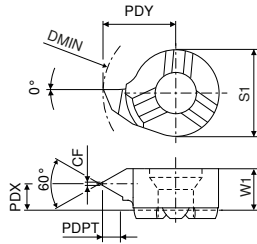
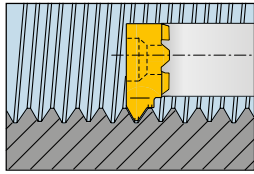
Illustrations show right-hand versions

Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left-hand	Right-hand
										Article no. 73 344 ...	Article no. 73 342 ...
08	8,00. R/L .0,5/0,75.60°	8	0,5 - 0,75	0,06	0,43	3,50	2,7	4,8	6,0	012	012
	8,00. R/L .1,0/1,25.60°	8	1,0 - 1,25	0,12	0,70	3,50	2,7	4,8	6,0	014	014
	8,00. R/L .1,5/1,75.60°	8	1,5 - 1,75	0,18	0,95	3,50	2,5	4,8	6,0	010	010
09	9,00. R/L .0,5/0,75.60°	9	0,5 - 0,75	0,06	0,27	3,55	3,2	5,5	6,2	112	112
	9,00. R/L .1,0/1,25.60°	9	1,0 - 1,25	0,12	0,54	3,55	3,0	5,5	6,2	114	114
	9,00. R/L .1,5/1,75.60°	9	1,5 - 1,75	0,18	0,81	3,55	2,8	5,5	6,2	116	116
	9,00. R/L .1,75/2,0.60°	9	1,75 - 2,0	0,20	0,95	3,55	2,6	5,5	6,2	118	118
	9,00. R/L .2,0/2,5.60°	9	2,0 - 2,5	0,25	1,08	3,55	2,5	5,5	6,2	120	120
	9,00. R/L .2,5/3,0.60°	9	2,5 - 3,0	0,31	1,35	3,55	2,1	5,5	6,2	122	122
	9,00. R/L .3,0/3,5.60°	9	3,0 - 3,5	0,37	1,62	3,55	1,9	5,5	6,2	124	124
11	11,00. R/L .0,5/0,75.60°	11	0,5 - 0,75	0,06	0,75	4,30	3,5	6,7	8,0	312	312
	11,00. R/L .1,0/1,25.60°	11	1,0 - 1,25	0,12	0,55	4,30	3,5	6,7	8,0	314	314
	11,00. R/L .1,5/1,75.60°	11	1,5 - 1,75	0,18	0,81	4,30	3,5	6,7	8,0	316	316
	11,00. R/L .2,0/2,5.60°	11	2,0 - 2,5	0,25	1,08	4,30	3,0	6,7	8,0	310	310
	11,00. R/L .2,5/3,0.60°	11	2,5 - 3,0	0,31	1,35	4,30	3,0	6,7	8,0	320	320
14	14,00. R/L .1,0/1,25.60°	14	1,0 - 1,25	0,12	0,55	5,40	4,7	9,0	9,0	512	512
	14,00. R/L .1,5/1,75.60°	14	1,5 - 1,75	0,18	0,81	5,40	4,5	9,0	9,0	514	514
	14,00. R/L .2,0/2,5.60°	14	2,0 - 2,5	0,25	1,08	5,40	4,2	9,0	9,0	510	510
	14,00. R/L .2,5/3,0.60°	14	2,5 - 3,0	0,31	1,35	5,40	4,7	9,0	9,0	520	520
16	16,00. R/L .1,0/1,25.60°	16	1,0 - 1,25	0,12	0,55	5,50	4,7	10,2	11,0	712	712
	16,00. R/L .1,5/1,75.60°	16	1,5 - 1,75	0,18	0,81	5,50	4,5	10,2	11,0	714	714
	16,00. R/L .2,0/2,5.60°	16	2,0 - 2,5	0,25	1,08	5,50	4,2	10,2	11,0	716	716
	16,00. R/L .2,5/3,0.60°	16	2,5 - 3,0	0,31	1,35	5,50	4,2	10,2	11,0	710	710

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials	•	•

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MiniCut – Threading insert (Full profile)



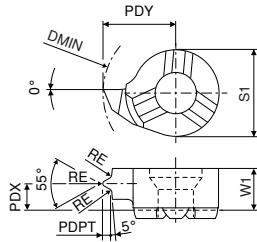
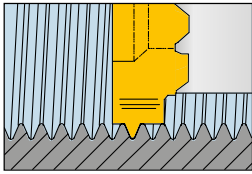
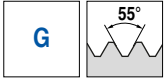
Illustrations show right-hand versions

Size	Designation	DMIN	TP	CF	PDPT	W1	PDX	PDY	S1	Left-hand	Right-hand
										Article no. 73 348 ...	Article no. 73 346 ...
09	9,00. R/L .0,5.60°	9	0,50	0,06	0,27	3,55	3,25	5,5	6,2	405	405
	9,00. R/L .1,0.60°	9	1,00	0,12	0,54	3,55	3,00	5,5	6,2	410	410
	9,00. R/L .1,5.60°	9	1,50	0,18	0,81	3,55	2,80	5,5	6,2	415	415
	9,00. R/L .1,75.60°	9	1,75	0,20	0,95	3,55	2,70	5,5	6,2	418	418
	9,00. R/L .2,0.60°	9	2,00	0,25	1,08	3,55	2,60	5,5	6,2	420	420
	9,00. R/L .2,5.60°	9	2,50	0,31	1,35	3,55	2,50	5,5	6,2	425	425
	9,00. R/L .3,0.60°	9	3,00	0,37	1,62	3,55	2,20	5,5	6,2	430	430
11	11,00. R/L .1,0.60°	11	1,00	0,12	0,54	4,30	3,50	6,7	8,0	314	314
	11,00. R/L .1,5.60°	11	1,50	0,18	0,81	4,30	3,50	6,7	8,0	316	316
	11,00. R/L .2,0.60°	11	2,00	0,25	1,08	4,30	3,20	6,7	8,0	310	310
	11,00. R/L .2,5.60°	11	2,50	0,31	1,35	4,30	3,00	6,7	8,0	320	320
	11,00. R/L .3,0.60°	11	3,00	0,37	1,62	4,30	2,90	6,7	8,0	330	330
14	14,00. R/L .0,5.60°	14	0,50	0,06	0,27	5,40	3,50	9,0	9,0	510	510
	14,00. R/L .1,0.60°	14	1,00	0,12	0,54	5,40	3,50	9,0	9,0	512	512
	14,00. R/L .1,5.60°	14	1,50	0,18	0,81	5,40	3,30	9,0	9,0	514	514
	14,00. R/L .2,0.60°	14	2,00	0,25	1,08	5,40	4,20	9,0	9,0	610	610
	14,00. R/L .2,5.60°	14	2,50	0,31	1,35	5,40	4,70	9,0	9,0	520	520
16	16,00. R/L .1,0.60°	16	1,00	0,12	0,54	5,50	4,70	10,2	11,0	712	712
	16,00. R/L .1,5.60°	16	1,50	0,18	0,81	5,50	4,50	10,2	11,0	714	714
	16,00. R/L .2,0.60°	16	2,00	0,25	1,08	5,50	4,20	10,2	11,0	716	716
	16,00. R/L .2,5.60°	16	2,50	0,31	1,35	5,50	4,20	10,2	11,0	710	710
	16,00. R/L .3,0.60°	16	3,00	0,37	1,62	5,50	4,00	10,2	11,0	720	720
	16,00. R/L .3,5.60°	16	3,50	0,43	1,89	5,50	3,80	10,2	11,0	730	730
	16,00. R/L .4,0.60°	16	4,00	0,50	2,16	5,50	3,60	10,2	11,0	740	740

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Threading insert (Full profile)



Illustrations show right-hand versions

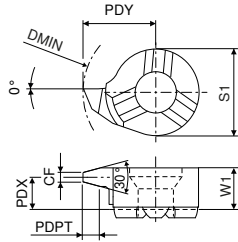
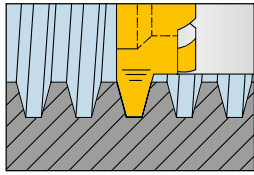
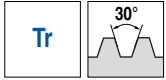
Size	Designation	DMIN mm	TP mm	TPI 1/"	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	Left-hand	Right-hand
											Article no. 73 352 ...	Article no. 73 350 ...
11	11,00. R/L .1,814.55°	11	1,814	14	1,16	4,30	3,0	6,7	8	0,24	306	306
	11,00. R/L .1,337.55°	11	1,337	19	0,85	4,30	2,7	6,7	8	0,18	304	304
14	14,00. R/L .1,814.55°	14	1,814	14	1,16	5,35	3,6	9,0	9	0,24	506	506
	14,00. R/L .1,337.55°	14	1,337	19	0,85	5,35	3,8	9,0	9	0,18	504	504
16	16,00. R/L .2,309.55°	16	2,309	11	1,48	5,50	3,5	10,2	11	0,31	708	708
	16,00. R/L .1,814.55°	16	1,814	14	1,16	5,50	3,9	10,2	11	0,24	706	706

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Threading insert (Partial profile)

▲ Trapezoidal thread DIN 103



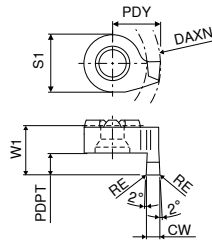
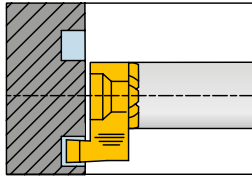
Illustrations show right-hand versions

Size	Designation	DMIN	TP	CF	PDPT	W1	PDX	PDY	S1	Left-hand	Right-hand
										Article no. 73 356 ...	Article no. 73 354 ...
09	9,00. R/L .1.5.30°	9	1,5	0,47	0,90	3,55	3,00	5,5	6,2	415	415
	9,00. R/L .2.0.30°	9	2,0	0,60	1,25	3,55	2,85	5,5	6,2	420	420
	9,00. R/L .3.0.30°	9	3,0	0,96	1,75	3,55	2,25	5,5	6,2	430	430
	9,00. R/L .4.0.30°	10	4,0	1,33	2,25	3,55	2,25	5,5	6,2	440	440
11	11,00. R/L .1.5.30°	11	1,5	0,47	0,90	4,30	3,70	6,7	8,0	315	315
	11,00. R/L .2.0.30°	11	2,0	0,60	1,25	4,30	3,50	6,7	8,0	320	320
	11,00. R/L .3.0.30°	11	3,0	0,96	1,75	4,30	3,20	6,7	8,0	330	330
	11,00. R/L .4.0.30°	11	4,0	1,33	2,25	3,95	2,60	6,7	8,0	340	340
14	14,00. R/L .2.0.30°	14	2,0	0,60	1,25	5,30	4,30	9,0	9,0	520	520
	14,00. R/L .3.0.30°	14	3,0	0,96	1,75	5,30	4,00	9,0	9,0	530	530
	14,00. R/L .4.0.30°	14	4,0	1,33	2,25	5,30	3,60	9,0	9,0	540	540
	14,00. R/L .5.0.30°	14	5,0	1,69	2,75	5,30	3,30	9,0	9,0	550	550
16	16,00. R/L .2.0.30°	16	2,0	0,60	1,25	5,50	4,50	9,7	11,0	720	720
	16,00. R/L .3.0.30°	16	3,0	0,96	1,75	5,50	4,30	9,7	11,0	730	730
	16,00. R/L .4.0.30°	16	4,0	1,33	2,25	5,50	4,00	9,7	11,0	740	740
	16,00. R/L .5.0.30°	16	5,0	1,69	2,75	5,50	3,55	9,7	11,0	750	750
	16,00. R/L .6.0.30°	16	6,0	1,92	3,50	5,50	3,30	10,2	11,0	760	760

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Axial grooving insert



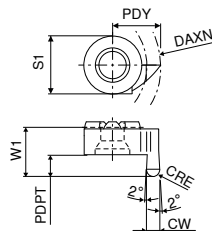
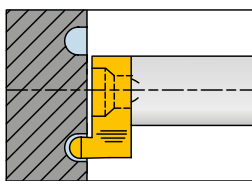
Illustrations show right-hand versions

Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left-hand	Right-hand
									Article no. 73 364 ...	Article no. 73 362 ...
14	14,00. R/L .1,0,1,5	14	1,0	1,5	8,3	9		9	510	510
	14,00. R/L .1,5,2,5	14	1,5	2,5	8,3	9	0,2	9	515	515
	14,00. R/L .2,0,3,0	14	2,0	3,0	8,3	9	0,2	9	520	520
	14,00. R/L .2,0,5,0	14	2,0	5,0	10,3	9	0,2	9	620	620
	14,00. R/L .2,5,3,0	14	2,5	3,0	8,3	9	0,2	9	525	525
	14,00. R/L .2,5,5,0	14	2,5	5,0	10,3	9	0,2	9	625	625
	14,00. R/L .3,0,3,0	14	3,0	3,0	8,3	9	0,2	9	530	530
	14,00. R/L .3,0,5,0	14	3,0	5,0	10,3	9	0,2	9	630	630

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials		

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MiniCut – Full radius axial grooving insert



12

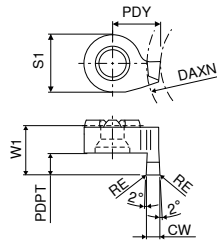
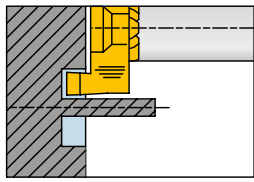
Illustrations show right-hand versions

Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	CRE mm	S1 mm	Left-hand	Right-hand
									Article no. 73 376 ...	Article no. 73 374 ...
14	14,00. R/L . 1,0,1,5	14	1,0	1,5	8,3	9	0,5	9	510	510
	14,00. R/L . 1,6,2,5	14	1,6	2,5	8,3	9	0,8	9	516	516
	14,00. R/L . 2,0,3,0	14	2,0	3,0	8,3	9	1,0	9	520	520
	14,00. R/L . 2,5,3,0	14	2,5	3,0	8,3	9	1,2	9	525	525
	14,00. R/L . 3,0,3,0	14	3,0	3,0	8,3	9	1,5	9	530	530

Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•
hardened materials		

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MiniCut – Axial grooving insert over a spigot



Illustrations show right-hand versions

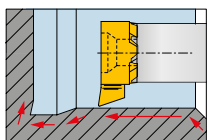
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left-hand	Right-hand
									Article no. 73 360 ...	Article no. 73 358 ...
12	12,00. R/L .1,0.1,5	12	1,0	1,5	8,3	7,0		9	310	310
	12,00. R/L .1,5.2,5	12	1,5	2,5	8,3	7,5	0,2	9	315	315
	12,00. R/L .2,0.3,0	12	2,0	3,0	8,3	8,0	0,2	9	320	320
	12,00. R/L .2,0.5,0	12	2,0	5,0	10,3	8,0	0,2	9	420	420
	12,00. R/L .2,5.3,0	12	2,5	3,0	8,3	8,5	0,2	9	325	325
	12,00. R/L .2,5.5,0	12	2,5	5,0	10,3	8,5	0,2	9	425	425
	12,00. R/L .3,0.3,0	12	3,0	3,0	8,3	9,0	0,2	9	330	330
	12,00. R/L .3,0.5,0	12	3,0	5,0	10,3	9,0	0,2	9	430	430

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

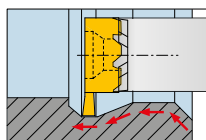
→ v_c Page 60

Set: MiniCut size 9

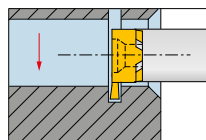
- ▲ Extensive range of size 9 inserts
- ▲ CWX 500



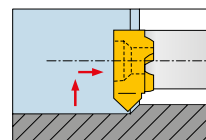
Profile turning (K)



Profile turn (A)



Grooving (E)

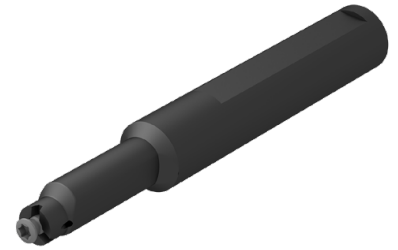
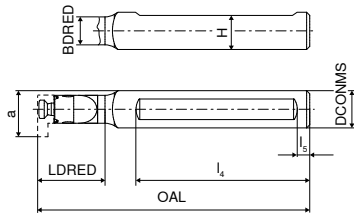


Chamfers (F)



Tool	Designation	Article number	Bore Ø mm	Width mm	Grooving depth mm	Piece	fig.	Article no. 73 528 ...
Grooving insert	9,00. R .1,00.1,8	73 310 210	9	1,00	1,8	1	E	125
NC fine turning insert	9,00. R .2,00.2,0	73 314 120	9	2,0 +0,05	2,0	1	A	
Profiling insert	9,00. R .3,60.10°	73 386 136	9	3,6		1	K	
Profiling insert	9,00. R .3,60.20°	73 322 236	9	3,6		1	K	
Chamfering insert	9,00. R .45°1,3	73 334 110	9		1,3	1	F	
Tool holder	9,00/16.N.25.1,0	73 522 125				1		
Tightening Key		70 950 105				1		

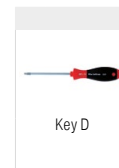
MiniCut – Steel Tool holder



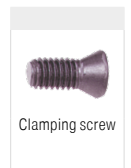
Size	Designation	a mm	DCONMS ₁₇ mm	OAL mm	l ₄ mm	LDRED mm	BDRED mm	H mm	l ₅ mm	Article no. 73 522 ...
08	8,00/16.N.12.1,0	7,8	16	80	60	12	6,0	15,0	5	012
	8,00/16.N.22.1,0	7,8	16	90	60	22	6,0	15,0	5	122
09	9,00/16.N.14.1,8	8,6	16	95	60	14	7,4	15,0	5	014
	9,00/16.N.25.1,8	8,6	16	105	60	25	7,4	15,0	5	125
11	11,00/16.N.16.2,3	10,7	16	97	60	16	8,0	14,5	5	016
	11,00/16.N.29.2,3	10,7	16	110	60	29	8,0	14,5	5	129
14	14,00/16.N.18.4,0	13,8	16	100	60	18	11,0	14,5	5	018
	14,00/16.N.38.4,0	13,8	16	120	60	38	11,0	14,5	5	138
16	16,00/16.N.22.4,3	15,7	16	100	60	22	11,0	14,5	5	022
	16,00/16.N.42.4,3	15,7	16	120	60	42	11,0	14,5	5	142

Spare parts

Size	Article no. 80 950 ...	Article no. 73 082 ...
08	T08	M2,6
09	T08	M2,6
11	T10	M3,5
14	T15	M4
16	T20	M5

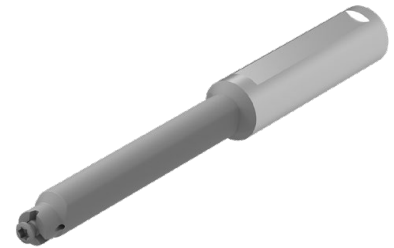
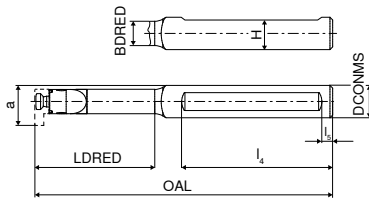


Key D



Clamping screw

MiniCut – Solid Carbide Tool holder – vibration damped

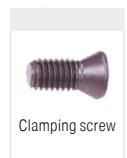
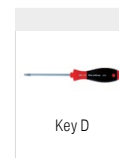


Size	Designation	a mm	DCONMS ₁₇ mm	OAL mm	l ₄ mm	LDRED mm	BDRED mm	H mm	l ₅ mm	Article no. 73 520 ...
08	8,00/12.N.21.1,0 HM	7,8	12	80	48	21	6,0	11,0	5	021
	8,00/12.N.30.1,0 HM	7,8	12	90	48	30	6,0	11,0	5	030
	8,00/12.N.42.1,0 HM	7,8	12	100	48	42	6,0	11,0	5	042
	8,00/12.N.50.1,0 HM	7,8	12	115	48	50	6,0	11,0	5	050
09	9,00/12.N.22.1,0 HM	8,6	12	90	60	22	7,4	11,0	5	222
	9,00/12.N.30.2,0 HM	8,6	12	98	60	30	7,4	11,0	5	230
	9,00/12.N.42.3,0 HM	8,6	12	110	60	42	7,4	11,0	5	242
	9,00/12.N.56.4,0 HM	8,6	12	122	60	56	7,4	11,0	5	256
11	11,00/12.N.29.2,3 HM	10,7	12	95	60	29	8,0	10,5	5	129
	11,00/12.N.42.2,3 HM	10,7	12	110	60	42	8,0	10,5	5	142
	11,00/12.N.56.2,3 HM	10,7	12	120	60	56	8,0	10,5	5	156
	11,00/12.N.64.2,3 HM	10,7	12	130	60	64	8,0	10,5	5	164
14	14,00/12.N.34.4,0 HM	13,8	12	100	60	34	11,0	10,5	5	234
	14,00/12.N.45.4,0 HM	13,8	12	110	60	45	11,0	10,5	5	245
	14,00/12.N.64.4,0 HM	13,8	12	130	60	64	11,0	10,5	5	264
	14,00/16.N.34.4,0 HM	13,8	16	100	60	34	11,0	14,5	5	334
	14,00/16.N.45.4,0 HM	13,8	16	110	60	45	11,0	14,5	5	345
	14,00/16.N.64.4,0 HM	13,8	16	130	60	64	11,0	14,5	5	364
	14,00/16.N.75.4,0 HM	13,8	16	145	60	75	11,0	14,5	5	375
16	16,00/12.N.40.4,3 HM	15,7	12	130	60	40	11,0	10,5	5	440
	16,00/12.N.56.4,3 HM	15,7	12	130	60	56	11,0	10,5	5	456
	16,00/12.N.80.4,3 HM	15,7	12	150	60	80	11,0	10,5	5	480
	16,00/16.N.40.4,3 HM	15,7	16	130	60	40	11,0	14,5	5	540
	16,00/16.N.56.4,3 HM	15,7	16	130	60	56	11,0	14,5	5	556
	16,00/16.N.80.4,3 HM	15,7	16	150	60	80	11,0	14,5	5	580

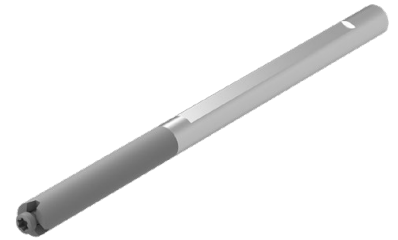
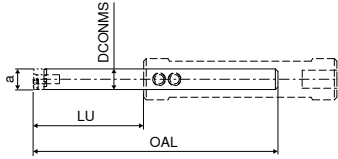
Spare parts

Size

Size	Article no. 80 950 ...	Article no. 73 082 ...
08	T08 110	M2,6 002
09	T08 110	M2,6 002
11	T10 112	M3,5 003
14	T15 113	M4 004
16	T20 114	M5 005



MiniCut – HM – Flexoholder

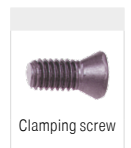
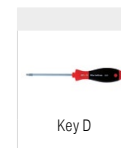


Size	Designation	DCONMS	OAL	LU	a	Article no. 73 525 ...
		mm	mm	mm		
08	8,0/6.N16/2	6	65	18	8	818
	8,0/6.N40/4	6	103	40	8	840
11	11,0/8.N20/2	8	79	20	11	120 ¹⁾
	11,0/8.N50/4	8	129	50	11	150 ¹⁾

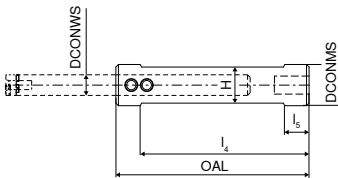
1) with thro' coolant

Spare parts

Size		Article no. 80 950 ...	Article no. 73 082 ...
08	T08	110	M2,6 002
11	T10	112	M3,5 003



MiniCut – Base holder for solid carbide Flexoholder

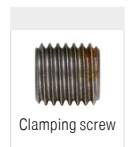
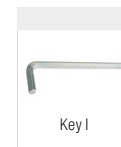


Size	Designation	DCONWS	DCONMS	H	OAL	l ₄	l ₅	Article no. 73 526 ...
		mm	mm	mm	mm	mm	mm	
08	8/16.75	6	16	14	75	55	10	816
	8/20.90	6	20	18	90	70	10	820
11	11/16.75	8	16	14	75	55	10	116
	11/20.90	8	20	18	90	70	10	120

12

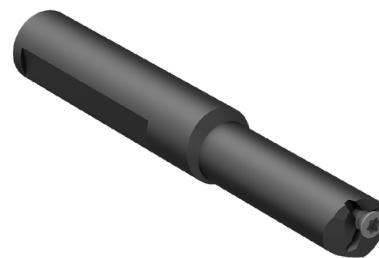
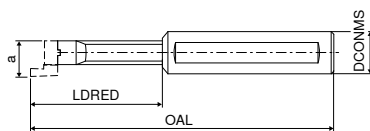
Spare parts

for Article no.		Article no. 70 950 ...	Article no. 73 082 ...
73 526 816	SW2,5	175	M5x0,5x6 010
73 526 820	SW2,5	175	M5x0,5x6 010
73 526 116	SW2,5	175	M5x0,5x4 009
73 526 120	SW2,5	175	M5x0,5x6 010



MiniCut – Steel holder

▲ for axial machining

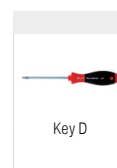


Illustrations show right-hand versions

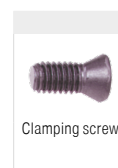
Size	Designation	a mm	DCONMS mm	OAL mm	LDRED mm	Left-hand		Right-hand	
						Article no. 73 523 ...	025 145	Article no. 73 524 ...	025 145
14	14,0/16. R/L .25.1,0	13,5	16	90	25				
	14,0/16. R/L .45.1,0	13,5	16	110	45				

Spare parts

Size	Key D	Clamping screw
14	Article no. 80 950 ... T15 113	Article no. 73 082 ... M4 004



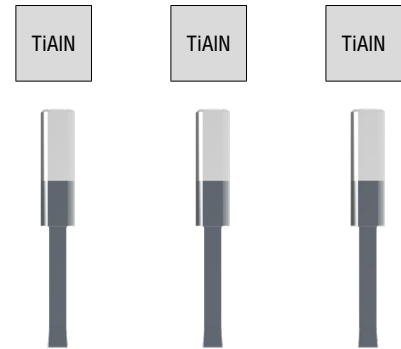
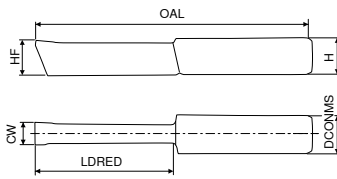
Key D



Clamping screw

SlotCut – Inserts – DIN 138

▲ b₁ = Groove width



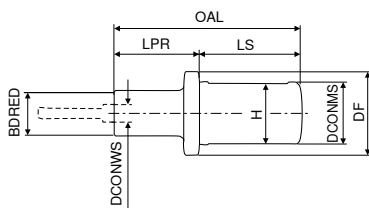
Designation	d ₁ P9/JS9/C11 mm	CW mm	HF mm	RE mm	OAL mm	LDRED mm	DAXN mm	DCONMS _{h6} mm	H mm	clamping holder	Article no. 73 600 ...	Article no. 73 601 ...	Article no. 73 602 ...
NPU.0198.01.1	2	1,98	5,5	0,10	38	12,5	6	7	6,3	NHU			099
NPU.0200.01.1	2	2,01	5,5	0,10	38	12,5	6	7	6,3	NHU		099	
NPU.0210.03.1	2	2,10	5,5	0,35	38	12,5	6	7	6,3	NHU	098		100
NPU.0298.01.1	3	2,98	6,2	0,10	38	12,5	7	7	6,3	NHU			100
NPU.0300.01.1	3	3,01	6,2	0,10	38	12,5	7	7	6,3	NHU			100
NPU.0310.03.1	3	3,10	6,2	0,35	38	12,5	7	7	6,3	NHU	099		
NPU.0310.05.1	3	3,10	6,2	0,50	38	12,5	7	7	6,3	NHU	100		
NPU.0398.01.1	4	3,98	6,2	0,10	40	15,0	7	7	6,3	NHU			101
NPU.0398.02.2	4	3,98	6,2	0,20	50	25,0	7	7	6,3	NHU			102
NPU.0400.01.1	4	4,01	6,2	0,10	40	15,0	7	7	6,3	NHU			101
NPU.0400.02.1	4	4,01	6,2	0,20	40	15,0	7	7	6,3	NHU			102
NPU.0400.02.2	4	4,01	6,2	0,20	50	25,0	7	7	6,3	NHU			103
NPU.0410.05.1	4	4,10	6,2	0,50	40	15,0	7	7	6,3	NHU	101		
NPU.0410.05.2	4	4,10	6,2	0,50	50	25,0	7	7	6,3	NHU	102		
NPU.0498.02.2	5	4,98	5,8	0,20	50	25,0	7	7	6,3	NHU			103
NPU.0500.02.2	5	5,01	5,8	0,20	50	25,0	8	7	6,3	NHU			103

i Tolerance **C 11** for 73 600 ..., Tolerance **JS 9** for 73 601 ..., Tolerance **P 9** for 73 602 ...

SlotCut – Toolholder for broaching inserts

Scope of supply:

Tool holder with clamping screw, without insert



12

Designation	DCONWS mm	BDRED mm	DCONMS _{g6} mm	DF mm	OAL mm	LS mm	LPR mm	H mm	Inserts	Article no. 73 610 ...
NHU.25	7	18	25	33	73	40	33	23	NPU	025
NHU.32	7	20	32	40	73	40	33	30	NPU	032

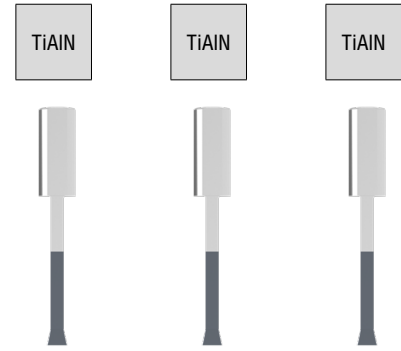
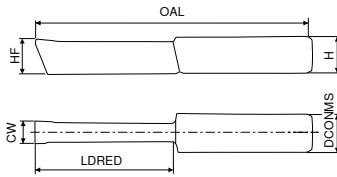
Spare parts

for Article no.

Article no.	Key I	Article no.	Clamping screw
73 610 025	SW2,5	70 950 ...	M5x6
73 610 032	SW2,5	70 950 ...	M5x6

SlotCut – Inserts – DIN 138

▲ b₁ = Groove width



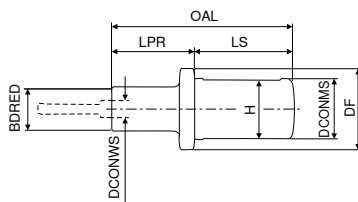
Designation	d _{1 JS9/P9/C11} mm	CW mm	HF mm	RE mm	OAL mm	LDRED mm	DAXN mm	DCONMS ₉₆ mm	H mm	clamping holder	Article no.	Article no.	Article no.
											73 606 ...	73 607 ...	73 608 ...
NP10.398.02.2	4	3,98	9	0,2	50	25	10	10	9,2	NH 10	101	101 102	101 102
NP10.398.02.3	4	3,98	9	0,2	66	41	10	10	9,2	NH 10			
NP10.400.02.2	4	4,01	9	0,2	50	25	10	10	9,2	NH 10	101 102	103 104	103 104
NP10.400.02.3	4	4,01	9	0,2	66	41	10	10	9,2	NH 10			
NP10.410.05.2	4	4,10	9	0,5	50	25	10	10	9,2	NH 10	103 104	103 104	103 104
NP10.410.05.3	4	4,10	9	0,5	66	41	10	10	9,2	NH 10			
NP10.498.02.2	5	4,98	9	0,2	50	25	10	10	9,2	NH 10	103 104	103 104	103 104
NP10.498.02.3	5	4,98	9	0,2	66	41	10	10	9,2	NH 10			
NP10.500.02.2	5	5,01	9	0,2	50	25	10	10	9,2	NH 10	103 104	103 104	103 104
NP10.500.02.3	5	5,01	9	0,2	66	41	10	10	9,2	NH 10			
NP10.510.05.2	5	5,10	9	0,5	50	25	10	10	9,2	NH 10	103 104	103 104	103 104
NP10.510.05.3	5	5,10	9	0,5	66	41	10	10	9,2	NH 10			

i Tolerance **C 11** for 73 606 ..., Tolerance **P 9** for 73 607 ..., Tolerance **JS 9** for 73 608 ...

SlotCut – Toolholder for Cutting Inserts

Scope of supply:

Tool holder with clamping screw, without insert



Designation	DCONWS mm	BRED mm	DCONMS ₉₆ mm	DF mm	OAL mm	LS mm	LPR mm	H mm	Inserts	Article no.
										73 612 ...
NH10.0025.1	10	20	25	33	73	40	33	23	NP10	025
NH10.0032.1	10	20	32	40	73	40	33	30	NP10	032

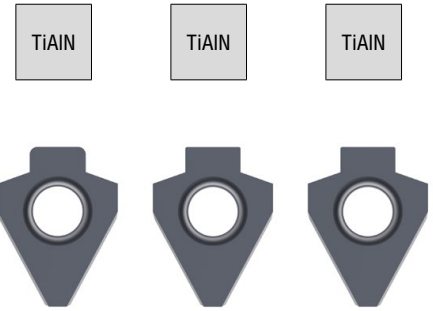
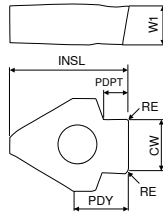
Spare parts

for Article no.

Article no.	Key I	Article no.	Grubscrew
73 612 032	SW03	70 950 ...	M6x5,5
73 612 025	SW03	70 950 ...	M6x5,5

SlotCut – Inserts – DIN 138

▲ b₁ = Groove width



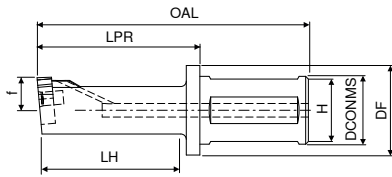
Designation	b ₁ P9/JS9/C11 mm	CW mm	RE mm	PDY mm	INSL mm	PDPT mm	DAXN mm	W1 mm	clamping holder	Article no. 73 603 ...	Article no. 73 604 ...	Article no. 73 605 ...
NV15.0398.02	4	3,98	0,20	6,5	13,0	2,3	15	3,2	NHV 15			110
NV15.0401.02	4	4,01	0,20	6,5	13,0	2,3	15	3,2	NHV 15		110	
NV15.0410.050	4	4,10	0,50	6,5	13,0	2,2	15	3,2	NHV 15	108		111
NV15.0498.02	5	4,98	0,20	6,5	13,0	2,8	15	3,2	NHV 15			111
NV15.0501.02	5	5,01	0,20	6,5	13,0	2,8	15	3,2	NHV 15		111	
NV15.0510.050	5	5,10	0,50	6,5	13,0	2,5	15	3,2	NHV 15	109		112
NV15.0598.02	6	5,98	0,20	6,5	13,0	3,3	15	3,2	NHV 15			112
NV15.0601.02	6	6,01	0,20	6,5	13,0	3,3	15	3,2	NHV 15		112	
NV15.0612.085	6	6,12	0,85	6,5	13,0	2,6	15	3,2	NHV 15	110		
NPV.0498.02	5	4,98	0,20	8,0	17,3	2,7	22	5,3	NHV 22			100
NPV.0501.02	5	5,01	0,20	8,0	17,3	2,7	22	5,3	NHV 22		100	
NPV.0598.02	6	5,98	0,20	8,0	17,3	3,4	22	5,3	NHV 22			101
NPV.0601.02	6	6,01	0,20	8,0	17,3	3,4	22	5,3	NHV 22		101	
NPV.0612.085	6	6,12	0,85	8,0	17,3	2,6	22	5,3	NHV 22	101		
NPV.0713.085	7	7,13	0,85	8,0	17,3	3,3	22	5,3	NHV 22	102		
NPV.0798.02	8	7,98	0,20	8,0	17,3	4,1	22	5,3	NHV 22/30			102
NPV.0801.02	8	8,01	0,20	8,0	17,3	4,1	22	5,3	NHV 22/30		102	
NPV.0813.105	8	8,13	1,05	8,0	17,3	3,4	22	5,3	NHV 22/30	103		
NPV.0998.03	10	9,98	0,30	8,0	17,3	4,2	30	5,3	NHV 30			103
NPV.1001.03	10	10,01	0,30	8,0	17,3	4,2	30	5,3	NHV 30		103	
NPV.1013.105	10	10,13	1,05	10,9	20,2	4,2	40	5,3	NHV 38	104		
NPV.1197.03	12	11,97	0,30	10,9	20,2	5,7	40	5,3	NHV 38			104
NPV.1202.05	20	12,02	0,50	10,9	20,2	8,5	40	5,3	NHV 38		105	
NPV.1202.03	12	12,02	0,30	10,9	20,2	5,7	40	5,3	NHV 38		104	
NPV.1215.135	12	12,15	1,35	10,9	20,2	5,1	40	5,3	NHV 38	105		
NPV.1215.175	16	12,15	1,75	10,9	20,2	6,6	40	5,3	NHV 38	106		
NPV.1215.225	24	12,15	2,25	10,9	20,2	8,5	40	5,3	NHV 38	107		
NPV.1397.03	14	13,97	0,30	10,9	20,1	7,5	45	5,3	NHV 45			106
NPV.1402.03	14	14,02	0,30	10,9	20,1	7,5	45	5,3	NHV 45		106	
NPV.1597.03	16	15,97	0,30	10,9	20,1	7,5	45	5,3	NHV 45			107
NPV.1602.03	16	16,02	0,30	10,9	20,1	7,5	45	5,3	NHV 45		107	
NPV.1797.05	18	17,97	0,50	10,9	20,1	9,5	45	5,3	NHV 45			108
NPV.1802.05	18	18,02	0,50	10,9	20,1	9,5	45	5,3	NHV 45		108	
NPV.1997.05	20	19,97	0,50	10,9	20,1	10,0	45	5,3	NHV 45			109
NPV.2002.05	20	20,02	0,50	10,9	20,1	10,0	45	5,3	NHV 45		109	

i Tolerance **C 11** for 73 603 ..., Tolerance **JS 9** for 73 604 ..., Tolerance **P 9** for 73 605 ...

SlotCut – Toolholder for inserts

Scope of supply:

Tool holder with clamping screw, without insert

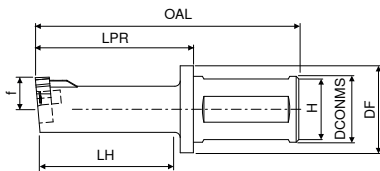


Designation	DCONMS _{g6}	DAXN	DF	OAL	LH	LPR	H	f	Inserts	Article no. 73 613 ...
	mm	mm	mm	mm	mm	mm	mm	mm		
NHV.15.1	25	15	33	75	25	35	23	8,4	NV15	025
NHV.15.2	25	15	33	90	40	50	23	8,4	NV15	125
NHV.15.3	25	15	33	110	60	70	23	8,4	NV15	225

SlotCut – Toolholder for inserts

Scope of supply:

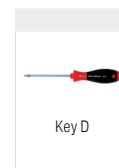
Tool holder with clamping screw, without insert



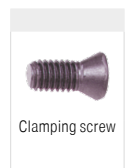
Designation	DCONMS _{g6}	DAXN	DF	OAL	LH	LPR	H	f	Inserts	Article no. 73 611 ...
	mm	mm	mm	mm	mm	mm	mm	mm		
NHV.22	25	22	33	100	50	60	23	12,0	NPV	025
NHV.30	32	30	45	100	50	60	30	16,5	NPV	032
NHV.30	32	30	45	125	75	85	30	16,5	NPV	532
NHV.38	32	38	45	100	50	60	30	22,0	NPV	132
NHV.38	32	38	45	125	75	85	30	22,0	NPV	632
NHV.45	40	45	55	120	50	60	38	24,0	NPV	040
NHV.45	40	45	55	175	105	115	38	24,0	NPV	140
NHV.45	40	45	55	225	155	165	38	24,0	NPV	240

Spare parts
DCONMS_{g6}

DCONMS _{g6}	T20	Article no. 80 950 ...	M5x13	Article no. 73 082 ...
25	T20	114	M5x13	007
32	T20	114	M5x13	007
40	T20	114	M5x13	007



Key D



Clamping screw

Material examples referring to the cutting data tables

	Index	Material	Strength N/mm ² / HB / HRC	Material number	Material designation	Material number	Material designation	Material number	Material designation
P	1.1	General construction steel	< 800 N/mm ²	1.0402	EN3B				
	1.2	Free cutting steel	< 800 N/mm ²	1.0711	EN1A				
	1.3	Hardened steel, non alloyed	< 800 N/mm ²	1.0401	EN32C				
	1.4	Alloyed hardened steel	< 1000 N/mm ²	1.7325	25 CD4				
	1.5	Tempering steel, unalloyed	< 850 N/mm ²	1.5752	EN36	1.0535	EN9		
	1.6	Tempering steel, unalloyed	< 1000 N/mm ²	1.6582	EN24				
	1.7	Tempering steel, alloyed	< 800 N/mm ²	1.7225	EN19				
	1.8	Tempering steel, alloyed	< 1300 N/mm ²	1.8515	EN40B				
	1.9	Steel castings	< 850 N/mm ²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3.7	1.6582	GS-34 CrNiMo 6
	1.10	Nitriding steel	< 1000 N/mm ²	1.8509	EN41B				
	1.11	Nitriding steel	< 1200 N/mm ²	1.1186	EN8	1.1160	EN14A		
	1.12	Roller bearing steel	< 1200 N/mm ²	1.3505	534A99				
	1.13	Spring steel	< 1200 N/mm ²		EN45		EN47		EN43
	1.14	High-speed steel	< 1300 N/mm ²	1.3343	M2	1.3249	M34		
	1.15	Cold working tool steel	< 1300 N/mm ²	1.2379	D2	1.2311	P20		
	1.16	Hot working tool steel	< 1300 N/mm ²	1.2344	H13				
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm ²	1.4581	318				
	2.2	Stainless steel, ferritic	< 750 N/mm ²	1.4000	403				
	2.3	Stainless steel, martensitic	< 900 N/mm ²	1.4057	EN57				
	2.4	Stainless steel, ferritic / martensitic	< 1100 N/mm ²	1.4028	EN56B				
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm ²	1.4542	17-4PH				
	2.6	Stainless steel, austenitic	< 750 N/mm ²	1.4305	303	1.4401	316	1.4301	304
	2.7	Heat resistant steel	< 1100 N/mm ²	1.4876	Incoloy 800				
K	3.1	Grey cast iron with lamellar graphite	100-350 N/mm ²	0.6015	Grade 150	0.6020	Grade 220	0.6025	Grade 260
	3.2	Grey cast iron with lamellar graphite	300-500 N/mm ²	0.6030	Grade 300	0.6035	Grade 350	0.6040	Grade 400
	3.3	Gray cast iron with spheroidal graphite	300-500 N/mm ²	0.7040	SG 400-12	0.7043	SG 370-17	0.7050	SG 500-7
	3.4	Gray cast iron with spheroidal graphite	500-900 N/mm ²	0.7060	SG 600-3	0.7070	SG 700-2	0.7080	SG 800-2
	3.5	White malleable cast iron	270-450 N/mm ²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	White malleable cast iron	500-650 N/mm ²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Black malleable cast iron	300-450 N/mm ²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Black malleable cast iron	500-800 N/mm ²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm ²	3.0255	1050 A	3.0275	1070 A	3.0285	1080 A (A8)
	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm ²	3.1325	2017 A (AU4G)	3.4335	7005 (AZ5G)	3.4365	7075 (AZ5GU)
	4.3	Aluminium alloy 0.5-10 % Si	< 400 N/mm ²	3.2315	A-G S1	3.2373	A-S9 G	3.2151	A-S 6 U4
	4.4	Aluminium alloys 10-15 % Si	< 400 N/mm ²	3.2581	A-S12	3.2583	A-S12 U		
	4.5	Aluminum alloys > 15 % Si	< 400 N/mm ²		A-S18		A-S17 U4		
	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm ²	2.0040	Cu-c1	2.0060	Cu-a1	2.0090	Cu-b1
	4.7	Copper wrought alloys	< 700 N/mm ²	2.1247	Cub2 (Beryllium Copper)	2.0855	CuN2S (Nickel Copper)	2.1310	CU-Fe2P
	4.8	Special copper alloys	< 200 HB	2.0916	Cu-A5	2.1525	Cu-S3 M		Ampco 8 (Cu-A6Fe2)
	4.9	Special copper alloys	< 300 HB	2.0978	Cu-Ai11 Fe5 Ni5)		Ampco 18 (Cu-A10 Fe3)		
	4.10	Special copper alloys	> 300 HB	2.1247	Cu Be2		Ampco M4		
	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm ²	2.0331	Cu Zn36 Pb1,5	2.0380	Cu Zn39 Pb2 (Ms 56)	2.0410	Cu Zn44 Pb2
	4.12	Long-chipping brass	< 600 N/mm ²	2.0335	Cu Zn 36 (Ms63)	2.1293	Cu Cr1 Zr		
	4.13	Thermoplastics			PE	PVC	PS	Polystyrene	Plexiglas
	4.14	Duroplastics			PF	Bakelite		Pertinax	
	4.15	Fibre-reinforced plastics				Carbon Fibre		Fibreglass	Aramid Fibre (Kevlar)
	4.16	Magnesium and magnesium alloys	< 850 N/mm ²	3.5812	Mg A7 Z1	3.5662	Mg A9	3.5105	Mg Tr3 Z2 Zn 1
	4.17	Graphite			R8500X		R8650		Technograph 15
	4.18	Tungsten and tungsten alloys			W-Ni Fe (Densimet)		W- Ni Cu (Inermet)		Denal
	4.19	Molybdenum and molybdenum alloys			TZM		MHO		Mo W
S	5.1	Pure nickel		2.4066	Ni99 (Nickel 200)	2.4068	Lc Ni99 (Nickel 201)		
	5.2	Nickel alloys		1.3912	Fe-Ni36 (Invar)	1.3917	Fe-Ni42 (N42)	1.3922	Fe-Ni48 (N48)
	5.3	Nickel alloys	< 850 N/mm ²	2.4375	Ni Cu30 Al (Monel K500)	2.4360	Ni Cu30Fe (Monel 400)	2.4668	
	5.4	Nickel molybdenum alloys		2.4600	Ni Mo30Cr2 (Hastelloy B4)	2.4617	Ni Mo28 (Hastelloy B2)	2.4819	Ni Mo16Cr16 Hastell. C276
	5.5	Nickel-chromium alloys	< 1300 N/mm ²	2.4951	Ni Cr20TiAl (Nimonic 80A)	2.4858	Ni Cr21Mo (Inconel 825)	2.4856	Ni Cr22Mo9Nb Inconel 625
	5.6	Cobalt Chrome Alloys	< 1300 N/mm ²	2.4964	Co Cr20 W15 Ni10		Co Cr20 Ni16 Mo7		Co Cr28 Mo 6
	5.7	Heat resistant alloys	< 1300 N/mm ²	1.4718	Z45 C S 9-3	1.4747	Z80 CSN 20-02	1.4845	Z12 CN 25-20
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm ²	2.4851	Ni Cr23Fe (Inconel 601)	2.4668	Ni Cr19NbMo (Inconel 718)	2.4602	Ni Cr21Mo14 Hastelloy C22
	5.9	Pure titanium	< 900 N/mm ²	3.7025	T35 (Titanium Grade 1)	3.7034	T40 (Titanium Grade 2)	3.7064	T60 (Titanium Grade 4)
	5.10	Titanium alloys	< 700 N/mm ²		T-A6-Nb7 (367)		T-A5-Sn2-Mo4-Cr4 (Ti17)		T-A3-V2,5 (Gr18)
	5.11	Titanium alloys	< 1200 N/mm ²	3.7165	T-A6-V4 (Ta6V)		T-A4-3V-Mo2-Fe2 (SP700)		T-A5-Sn1-Zr1-V1-Mo (Gr32)
H	6.1		< 45 HRC						
	6.2		46-55 HRC						
	6.3	Tempered steel	56-60 HRC						
	6.4		61-65 HRC						
	6.5		65-70 HRC						

Cutting data approximate values

	UltraMini K10F	UltraMini K10F-TiN	UltraMini K10-TiAlN	UltraMini DPX 57S	MiniCut CWX500	UltraMini TiAlN+	MiniCut CBN	UltraMini	MiniCut
Index	v_c in m/min							f in mm/rev.	
1.1	30-130	30-180	80-200	80-200	80-200				
1.2	30-130	40-200	80-200	80-200	80-200				
1.3	30-130	40-180	80-200	80-200	80-200				
1.4	15-90	30-140	80-160	80-160	80-160				
1.5	15-90	30-100		80-140					
1.6	15-90	30-100	80-160	80-160	80-160				
1.7	30-130	30-100	80-160	80-160	80-160				
1.8	15-90	30-100	80-150	80-150	80-150				
1.9	30-130	40-200	80-200	80-200	80-200				
1.10	15-90	30-100	70-140	70-140	70-140				
1.11	15-90	30-100	70-140	70-140	70-140				
1.12	15-90	30-100	70-140	70-140	70-140				
1.13									
1.14									
1.15	15-45	30-100							
1.16	15-45	30-100							
2.1		30-100	80-160	80-160	80-160				
2.2		30-100	80-160	80-160	80-160				
2.3		30-100	80-160	80-160	80-160				
2.4		20-90	20-85	20-85	20-85				
2.5		20-65	20-75	20-75	20-75				
2.6		20-80	20-65	20-65	20-65				
2.7		20-80	20-65	20-65	20-65				
3.1	30-110	70-150	30-180	30-180	30-180				
3.2	30-90	50-120	30-150	30-150	30-150				
3.3	25-110	30-130	30-180	30-180	30-180				
3.4	25-80	30-110	30-120	30-120	30-120				
3.5	30-110	30-100	30-90	30-90	30-90				
3.6	30-90	30-90	20-80	20-80	20-80				
3.7	30-110	30-100	30-90	30-90	30-90				
3.8	30-90	30-90	20-80	20-80	20-80				
4.1	110-210	100-600	120-600	120-600	120-600				
4.2	90-200	100-600	120-600	120-600	120-600				
4.3	90-200	100-500	100-450	100-450	100-450				
4.4	50-140	80-350	70-300	70-300	70-300				
4.5		80-200	60-150	60-150	60-150				
4.6	50-140	70-160	60-150	60-150	60-150				
4.7	60-150	80-180	100-180	100-180	100-180				
4.8	50-140	80-180	90-180	90-180	90-180				
4.9	50-140	80-180	80-180	80-180	80-180				
4.10	50-140	80-180	80-180	80-180	80-180				
4.11	80-160	100-200	120-220	120-220	120-220				
4.12	50-120	80-180	70-150	70-150	70-150				
4.13	40-120	70-160	80-180	80-180	80-180				
4.14									
4.15									
4.16									
4.17									
4.18	15-70								
4.19									
5.1		30-80	30-80	30-80	30-80				
5.2		18-75	18-75	18-75	18-75				
5.3		18-75	18-75	18-75	18-75				
5.4				40-70		55-75			
5.5		18-40	18-40	40-70	18-40	55-75			
5.6		18-40	18-40	40-70	18-40	55-75			
5.7		15-30	15-30	40-70	15-30	55-75			
5.8		15-30	15-30	40-70	15-30	55-75			
5.9		15-30	15-30	70-150	15-30				
5.10				70-150					
5.11				70-150					
6.1									
6.2						70-100			
6.3						70-100	50		
6.4						70-100	50		
6.5									

Internal turning and profiling	0,02-0,05	0,03-0,10
Internal turning and profiling - hard turning	0,02-0,06	0,03-0,10
Turning and profile turning - super alloys	0,02-0,08	
Internal turning	0,02-0,05	0,01-0,03
Back boring	0,02-0,04	0,03-0,10
Turning and chamfering	0,01-0,03	0,03-0,10
Pre-parting and chamfering	0,01-0,02	0,01-0,03
Groove turning	0,01-0,02	0,01-0,03
Internal Undercuts	0,01-0,03	0,03-0,08
Groove and profile turning	0,01-0,02	0,01-0,03
Axial grooving	0,02-0,05	0,02-0,05

i The cutting data depends largely on the external conditions, e.g. stability of the tools and tool clamping, material and machine type. The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.

Cutting data standard values – 73 000 ... / 73 001 ...

Index	UltraMini DPX77S v _c in m/min	Corner radius in mm			
		0,05	0,1	0,15	0,2
		f in mm/rev.			
1.1	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.2	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.3	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.4	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.5	80–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.6	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.7	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.8	80–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.9	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.10	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.11	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.12	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.13					
1.14					
1.15					
1.16					
2.1	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.2	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.3	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.4	20–85	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.5	20–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.6	20–65	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.7	20–65	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.1	30–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.2	30–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.3	30–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.4	30–120	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.5	30–90	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.6	20–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.7	30–90	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.8	20–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.1	120–600	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.2	120–600	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.3	100–450	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.4	70–300	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.5	60–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.6	60–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.7	100–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.8	90–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.9	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.10	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.11	120–220	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.12	70–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.13	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.14					
4.15					
4.16					
4.17					
4.18					
4.19					
5.1	30–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.2	18–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.3	18–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.4	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.5	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.6	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.7	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.8	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.9	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.10	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.11	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
6.1					
6.2					
6.3					
6.4					
6.5					

i The cutting data depends largely on the external conditions, e.g. stability of the tools and tool clamping, material and machine type. The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.

Broaching – Recommendations for Correct Use

SlotCut

More and more often small and medium sized batch sizes are manufactured with precision grooves.

To directly machine such grooves in one set-up on one machine, it requires a special application of "Broaching" tools.

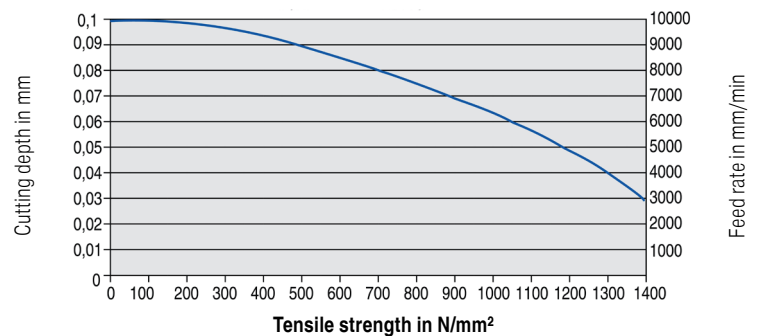
The SlotCut system can produce grooves with the most common groove tolerances.

To this end, there are four options. Two concepts are based on a solid carbide solution, which gives great success with small diameters.

For larger diameters, the concept with screw-on inserts is more suitable.

Broaching, on both lathes and machining centers is now economical, and provides highly accurate results in the shortest possible time.

Approximate values when broaching



i The data depends strongly on the conditions and represent only an approximate value, factors such as machine stability, application and material may require adjustment of the data upward or downward.



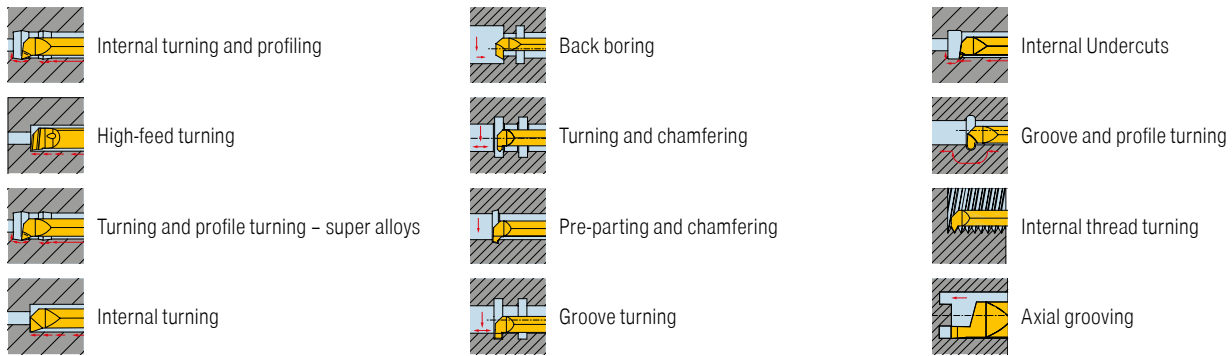
Tips for the User

- ▲ Avoid interrupted cuts.
- ▲ Lift the tool out of the groove when retracting.
- ▲ Where possible, orientate the part so the groove is at the top, so the chips fall away!
- ▲ Use coolant. This will increase tool life and surface quality.
- ▲ Ensure there is a relief at the end of the groove.
- ▲ Adjustment of the tool is essential, therefore the tool diameter must be considered.

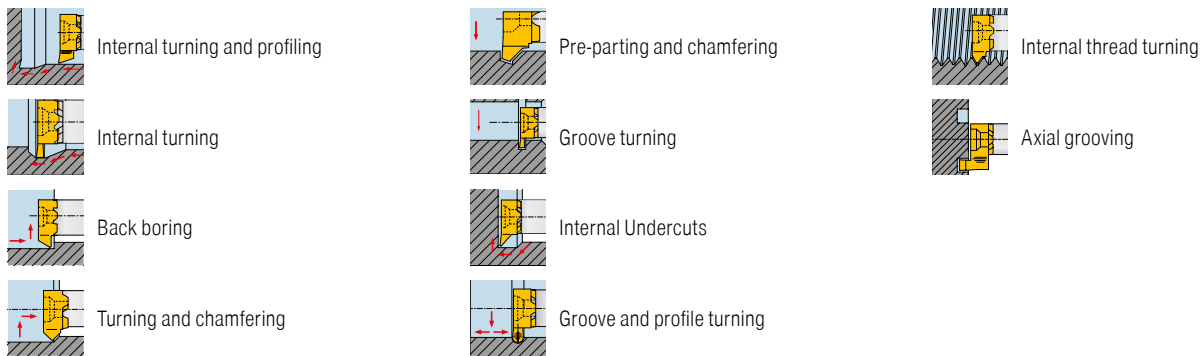


Symbol explanation

UltraMini



MiniCut



Coatings

TiAlN+

- ▲ TiAlN multilayer coating
- ▲ Maximum application temperature: 1000 °C

TiN

- ▲ TiN coating
- ▲ Maximum application temperature: 450 °C

TiAlN

- ▲ TiAlN multilayer coating
- ▲ Maximum application temperature: 900 °C

CWX500

- ▲ Carbide, TiAlN-coated
- ▲ ISO | **K30**
- ▲ The universal carbide grade for almost all materials

DXP77S

- ▲ TiAlN+X-coating
- ▲ Maximum application temperature: 900 °C

DPX57S

- ▲ TiCrN coating
- ▲ Maximum application temperature: 900 °C

Thread types

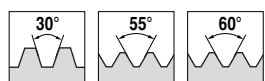
M Metric ISO standard thread

MF Metric ISO fine thread

G Whitworth thread

Tr Metric ISO trapezoidal fine thread

Thread flank angle



Coolant

